Date: Monday, 4/16/2007 2:21:29 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: SPACEPOD ASSEMBLY LH/ DSI 9335
Job Number	: 31767			
Estimate Number	: 12775			
P.O. Number	: N/A		Part Number	: D350600241
This Issue	: 4/16/2007	S.O. No. : N/A	Drawing Number	: D3188 REV.E,ICA REV Z
Prsht Rev.	: NC		Project Number	: N/A
First Issue	: N/A	Type : SMALL /MED FAB	Drawing Revision	: E, Z
Previous Run	: 31811		Material	: N/A
Written By	:		Due Date	: 5/5/2007 Qty: 1 Um: Each
Checked & Approved By	: KJ 07.04.16			
Comment	: Est Rev:A 07.03.07 new issue ec			
	est rev B 07.04.16 reformat,D3188 revE ec			

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	
	Comment: DOCUMENT CONTROL Photocopy bluefile and type labels as per PPP D350-600-241 CHG001		KJ 07.04.17.
2.0	31767A	SPACEPOD BODY LH w/o 30024	ml 07/04/17
	Comment: Sub-Component SPACEPOD BODY LH D3188-1M Batch:________		
3.0	31767B	SPACEPOD DOOR LH w/o 30014	ml 07/04/17
	Comment: Sub-Component SPACEPOD DOOR LH		
4.0	D31871	Spacepod Floor	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3187-1 Floor B25404 1 D3186-3 Door (ref) ~~N/A~~ 31767B 1 D3188-1 Body(ref) N/A		✓ ml 07/04/17
5.0	~~ALS41032130~~ AELS 1032130	Insert as QSI .017	
	Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s) insert batch: M 102776		

Form: mprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** _______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:21:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767

Part Number: D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	AN3235020935	WASHER
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) WASHER M103962 ml 07/04/17	
7.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Transfer drill (#30) from D3187-1 into D3188-1. 2-Open holes in D3188-1 body floor to Ø0.297". 3-Install inserts in D3188-1 as per Dwg D3188. 4-Open holes in D3187-1 aluminum floor to 0.250" per dwg D3187 5-Deburr holes in D3187-1 ml 07/04/17	
8.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP SB 07/04/18 (1)	
9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 (1)
	Comment: HAND FINISHING RESOURCE #1 ********D3187-1 floor only************* Chemical Conversion Coat as per QSI 005 4.1 m-l 07/04/18	
10.0	POWDER COATING	POWDER COATING M 102316
	Comment: POWDER COATING *********D3187-1 floor only********** Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 [illegible] 07-04-19 (1)	
11.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION (1)
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION m-l 07/04/19	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 4/16/2007 2:21:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | **Drawing Name:** SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767 | **Part Number:** D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	D2986	Black Neoprene foam .125

Comment: Qty.: 5.9010 sf(s)/Unit Total : 5.9010 sf(s)
neoprene foam
batch: B 30632 ✓ ml 07/04/25

Seq. #:	Machine Or Operation:	Description :
13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut D2986 Neoprene Foam per template D2986T1

ml 07/04/25

Seq. #:	Machine Or Operation:	Description :
14.0	QC5	INSPECT WORK TO CURRENT STEP

N/A ml

Comment: INSPECT WORK TO CURRENT STEP

Seq. #:	Machine Or Operation:	Description :
15.0	D30153	Lock Nut

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Lock Nut
batch: B30169 ✓

Seq. #:	Machine Or Operation:	Description :
16.0	D35547	BALL STUD

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
BALL STUD
batch: B30210 ✓

Seq. #:	Machine Or Operation:	Description :
17.0	D35671	DECAL

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
DECAL
batch: B 31127 ✓

Seq. #:	Machine Or Operation:	Description :
18.0	D2237	Striker Plate

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Batch: ~~B28288~~ B 30680 ✓

ml 07/04/17

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Monday, 4/16/2007 2:21:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767

Part Number: D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :	
19.0	MS20426AD45	Rivet	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Pick: Batch: M4067		✓
20.0	D35381	HINGE BRACKET	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) HINGE BRACKET batch: B30866		✓
21.0	D2179	Doubler	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Batch: B21490		✓
22.0	AN526C832R24	screw	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Screw batch: M103574		✓
23.0	AN960JD8	Washer	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Washer batch: M102455		✓
24.0	MS21042L08	Nut	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Nut batch: M103830		✓ ml 07/04/17
25.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1 ***this step seperates hardware, previous steps is for body & floor****		N/A ml

Form: mprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:21:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767
Part Number: D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :	
26.0	MS270390811	Screw	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Screw batch: M103585		✓
27.0	AN960JD8	Washer	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Washer batch: M102455		✓
28.0	NAS1515H3	Washer	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer batch: M100993		✓
29.0	MS21042L08	Nut	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut batch: M103830		✓
30.0	D2464	3/4 Seal	
	Comment: Qty.: 11.3400 f(s)/Unit Total : 11.3400 f(s) 3/4 Seal Cut 127.00" long batch: B30681		✓
31.0	D35671	DECAL	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) DECAL batch: B31127		✓
32.0	D2586	Door Latch	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Door Latch batch: B29021		✓ ML 07/04/17

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:21:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767 **Part Number:** D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :	
33.0	D2585	Latch Clamp	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Latch Clamp batch: B30814		✓
34.0	D2621	Latch Plate	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Latch Plate batch: B29995		✓
35.0	MS27039115	Screw	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Screw batch: M18057		✓
36.0	AN960JD10	Washer	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer batch: M15829		✓
37.0	MS21042L3	Nut	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut batch: M102658		✓
38.0	D28571	Hinge Bracket	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Hinge Bracket batch: B29051		✓
39.0	D28572	Hinge Bracket	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Hinge Bracket batch: B29022		✓ ML 07/04/17

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:21:29 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services | Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767 | Part Number: D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :
40.0	D2228	Backing Plate
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) Backing Plate batch: m30679	✓
41.0	AN526C832R10	Screw
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s) Screw batch: M103585	✓
42.0	AN960JD8	Washer
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Washer batch: M103492	✓
43.0	MS21042L08	Nut
	Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s) Nut batch: M103830	✓
44.0	D35571	BRACKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BRACKET batch: B30644	✓
45.0	AN526C832R14	Screw
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Screw batch: M9216	✓
46.0	AN526C832R10	Screw
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Screw batch: M103585	✓ ml 07/04/17

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767

Part Number: D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :
47.0 (47. A)	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
Assemble D3186-1 door with D3188-1 body as per Dwg ICA-D350-600
Hardware on previous steps is for door ass'y*

1-drill and plug section I-I and J-J of dwg D3188 p.11 using Hysol 934NA with milled glass fibres 10% to weight
A/R Hysol batch: M103922 expire date: Mars 2008
A/R Milled fibres batch: M100859

2-Attach Neoprene Foam using Contact Cement
A/R Contact Cement Batch: M102565

ml 07/04/26

Seq. #:	Machine Or Operation:	Description :
48.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/04/26 (1)

Seq. #:	Machine Or Operation:	Description :
~~49.0~~ 47.B	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Wing Walk Spacepod top surface of Pod as per Dwg D3188 & QSI 005 4.4
Batch: M103707

m-l 07/04/18

Seq. #:	Machine Or Operation:	Description :
~~50.0~~ 47C	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: Inspect Wing Walk

ml 07/04/26

Seq. #:	Machine Or Operation:	Description :
51.0	K10021	Spacepod Hardware Kit (-241)

Comment: Qty.: 1.0000 (s)/Unit Total : 1.0000 (s) B31842

Seq. #:	Machine Or Operation:	Description :
52.0	D350600449	SWITCH RELOCATION KIT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
SWITCH RELOCATION KIT B31898

Seq. #:	Machine Or Operation:	Description :
53.0	D2985	Label

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Label B27863

07/4/26

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:21:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767 **Part Number:** D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :
54.0	D35471	BRACKET
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BRACKET batch: B31124 /	
55.0	D35501	STRUT
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) STRUT batch: B31148 /	
56.0	D35527	CARBON STEEL GAS SPRING
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) CARBON STEEL GAS SPRING batch: B31149 /	
57.0	D35547	BALL STUD
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) BALL STUD batch: B30210 /	
58.0	AN960JD516	Washer
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Washer batch: M102519 /	
59.0	D30153	Lock Nut
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Lock Nut batch: B30169 /	
60.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
	Comment: INSPECT 100% KITS FOR COMPLETENESS	

07/04/26 C 2007/04/26

Form: mprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________________ **PAR #:** _______ **Fault Category:** ________________ **NCR:** Yes $\boxed{\text{No}}$ **DQA:** [signature] **Date:** 07/04/27

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:21:30 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SPACEPOD ASSEMBLY LH/ DSI 9335

Job Number: 31767
Part Number: D350600241

Job Number:

Seq. #:	Machine Or Operation:	Description :
61.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-600-141
Location:____________
PPP Rev:____________ Rev B 07/04/26 7/4/26 SQ

Seq. #:	Machine Or Operation:	Description :
62.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/04/27

Job Completion 07/04/27

Form: rprocess

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

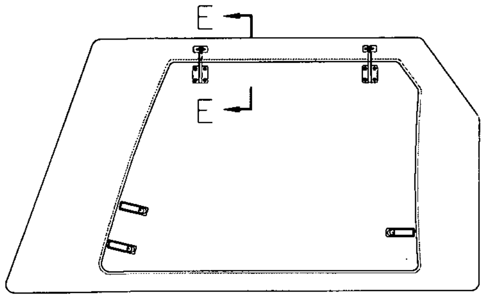


FIGURE 3. LOOKING AT OUTSIDE OF D350-600-145 DOOR (D350-600-146 SIMILAR AND OPPOSITE)

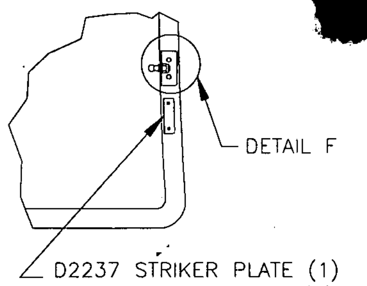


FIGURE 4. TYPICAL DOOR FRAME (AFT EDGE)

No good drawing

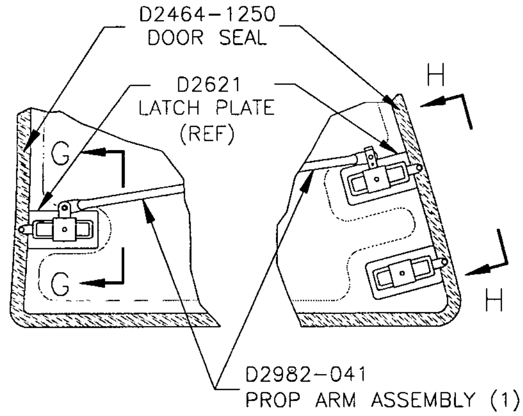
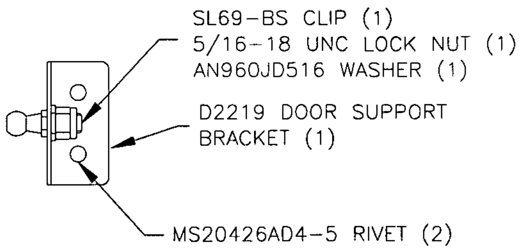


FIGURE 5. LOOKING AT TYPICAL INSIDE OF D350-600-145/-146 DOOR



DETAIL F

11N pg. 11 + 18-21

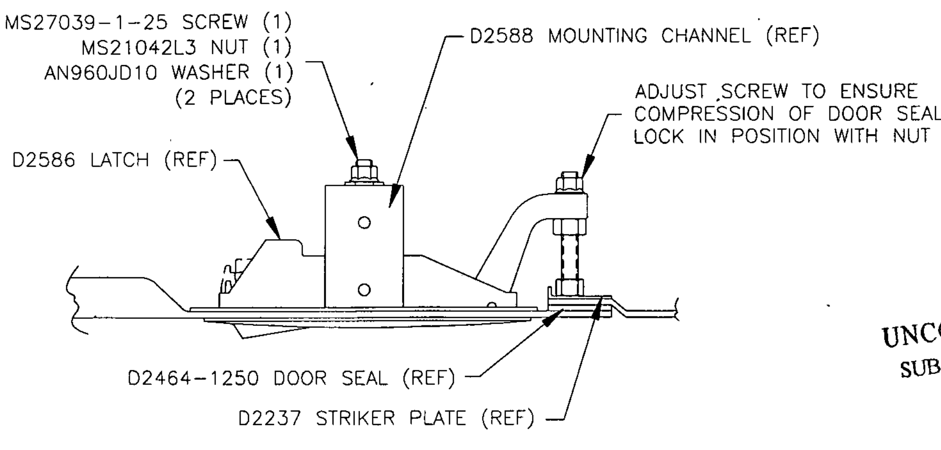
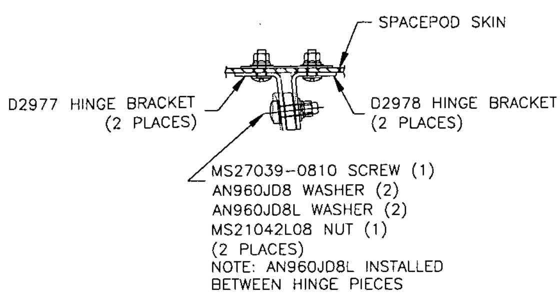
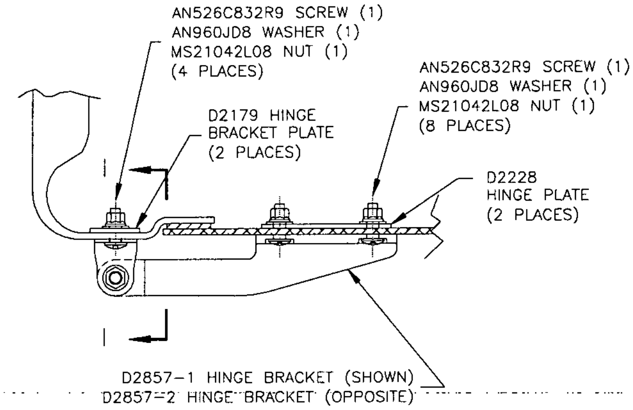


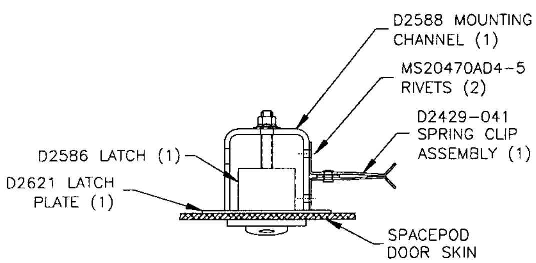
FIGURE 6. TYPICAL LATCH INSTALLATION



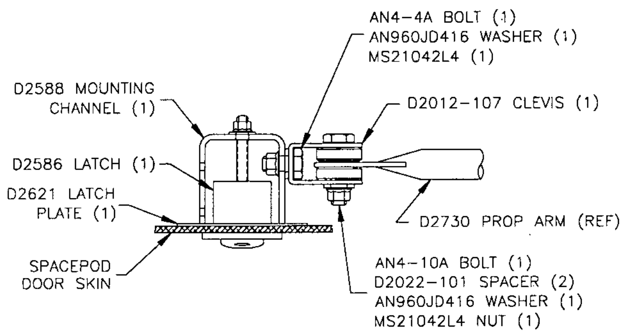
SECTION I-I: HINGE BRACKET



SECTION E-E: HINGE DETAIL FROM FIGURE 3



SECTION H-H: FWD LATCH



SECTION G-G: AFT LATCH

25.3 *SPACEPOD™* REMOVAL

1. Remove D350-600-045/-145 or –046/-146 door.
2. Remove battery shelf and wiring covers as applicable.
3. Loosen floor and D2174-041 bracket fasteners shown in section A-A, B-B, and C-C of Figure 2. Leave inserts in the compartment floor.
4. Remove ***Spacepod™*** body from the compartment.
5. Remove D2174-041 brackets.
6. Re-install battery shelf and wiring covers.
7. Re-install outboard tiedown "D" rings.
8. Re-install door latch tiedown brackets in the compartment floor.
9. Re-install baggage retaining net.
10. Re-install original side baggage compartment door.

GENERAL NOTES:

1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3) MATERIALS:

   RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

   FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
   12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
   18 oz ROVING "E" GLASS (18 oz CLOTH)
   OWENS CORNING MILLED FIBERS, "E" GLASS
   3M K20 GLASS BUBBLES

   FOAM: A500 CORE CELL
   OR DIVINYCELL
   OR AIREX
   OR KLEGECELL
   FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7) ALL DIMENSIONS ARE IN INCHES
8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED 07.04.09

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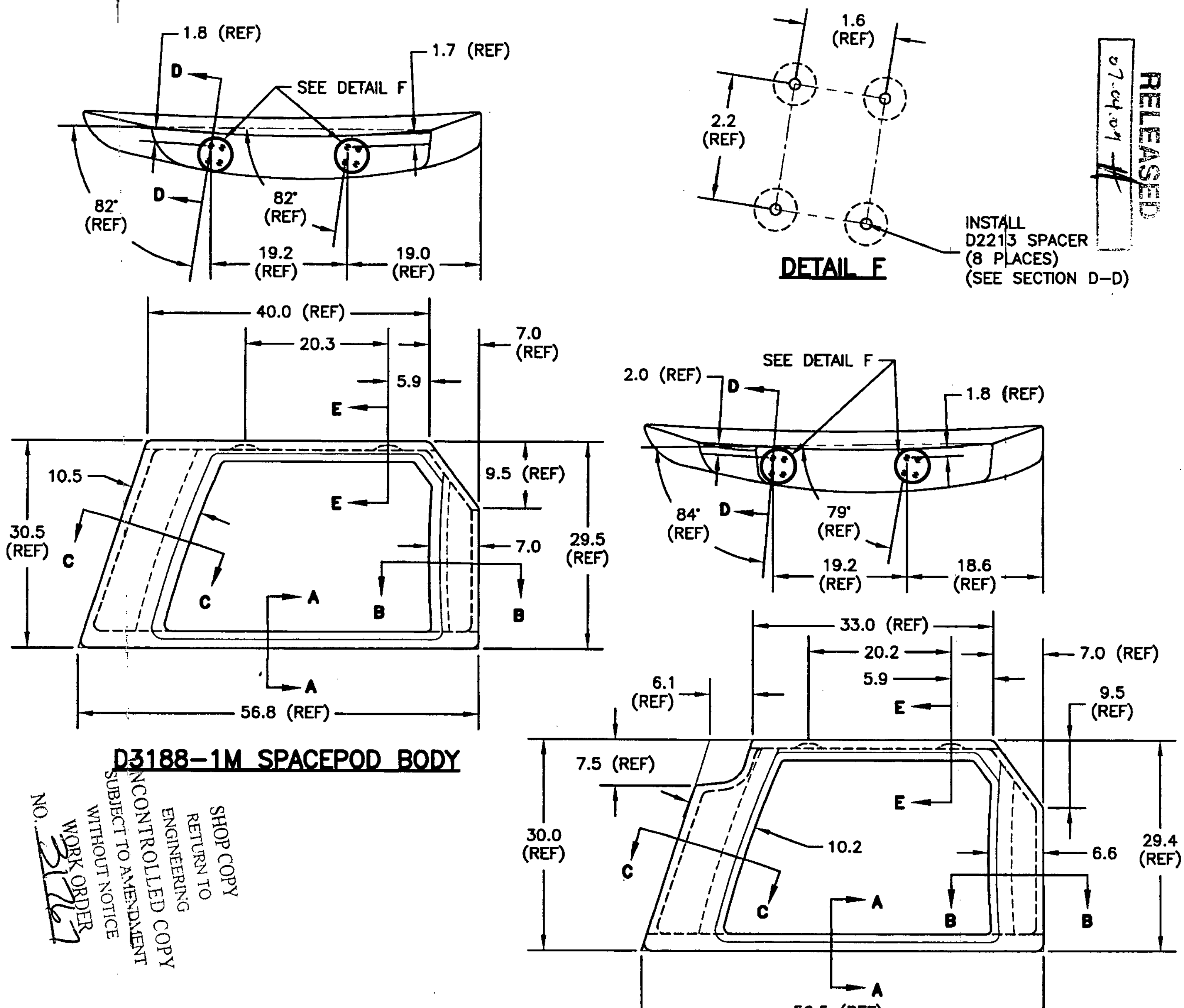
WORK ORDER NO 31767

DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA.

DESIGN	DRAWN BY	DRAWING NO.	REV.
JB	CB	D3188	E
CHECKED	APPROVED	TITLE	SHEET 1 OF 11
DATE 07.04.02		SPACEPOD BODY	SCALE NTS

REV	DATE	DESCRIPTION
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11



D3186-1M/-3M NOTES:

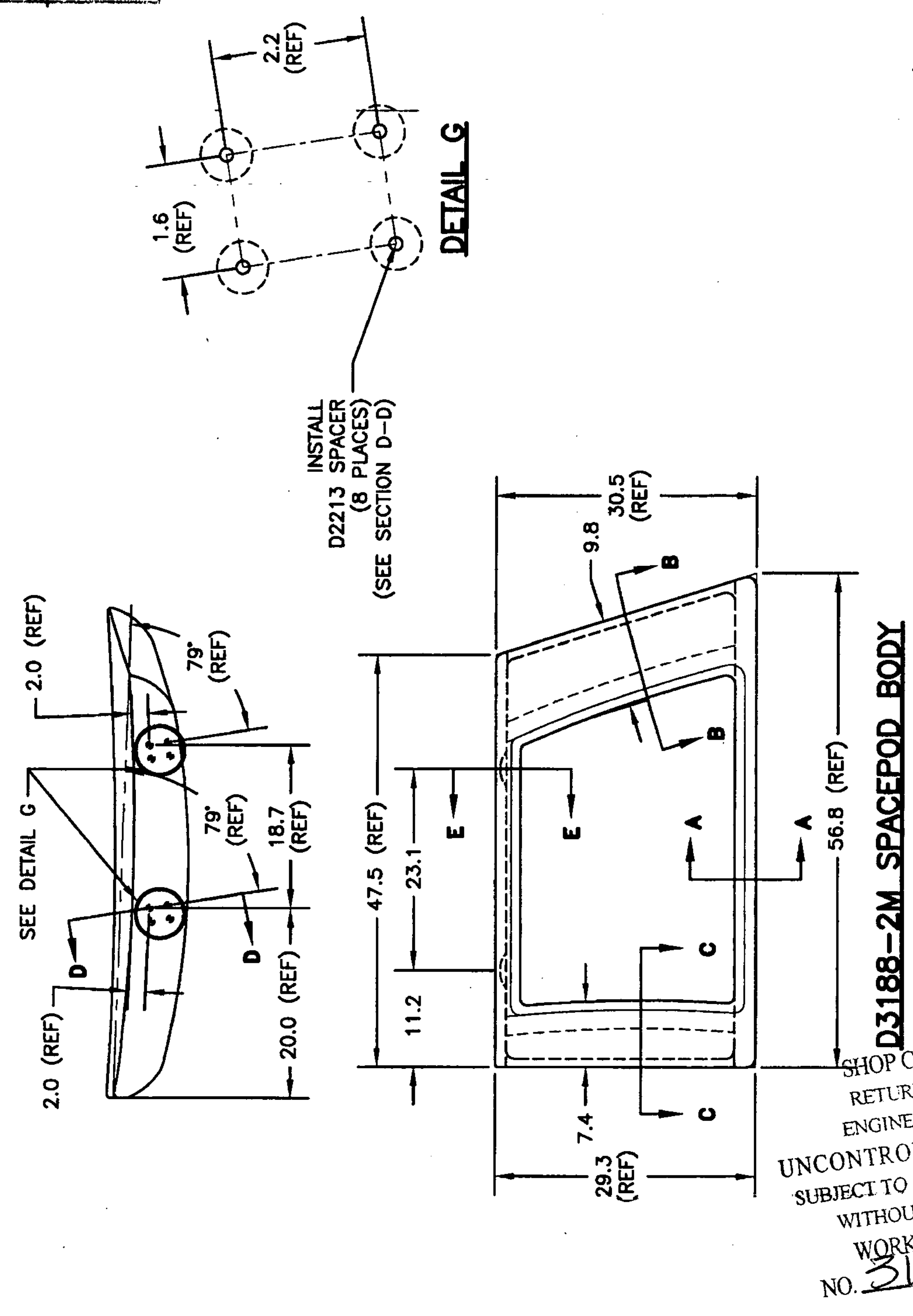
1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2) SEE SHEET #4 FOR SECTION VIEWS.

D3188-3M SPACEPOD BODY

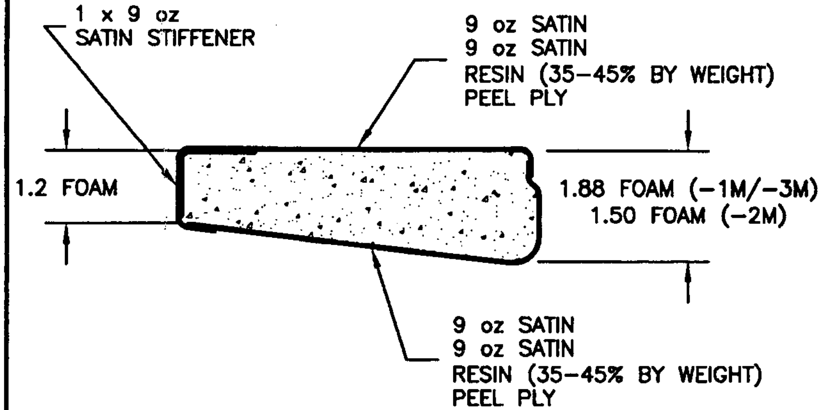
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB	CB	
CHECKED	APPROVED	DRAWING NO. D3188 — REV. E — SHEET 2 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY — SCALE NTS

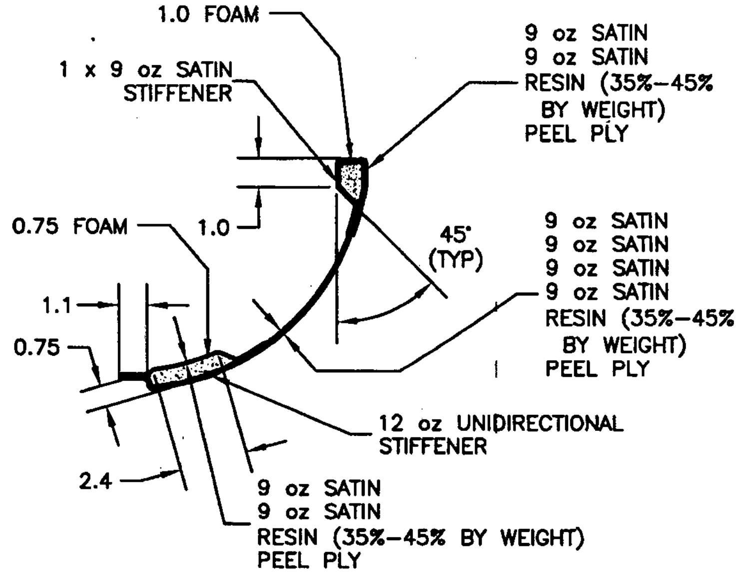
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CB		
CHECKED	APPROVED	DRAWING NO.	REV. E
LE	[illegible]	D3188	SHEET 3 OF 11
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS



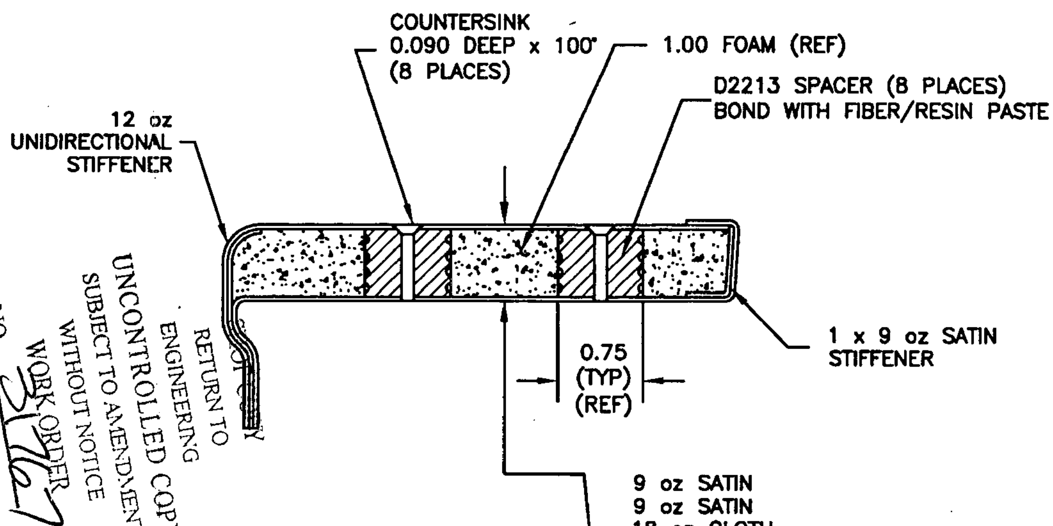
D3186–2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.



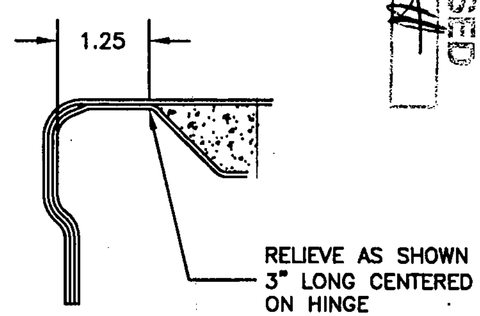
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

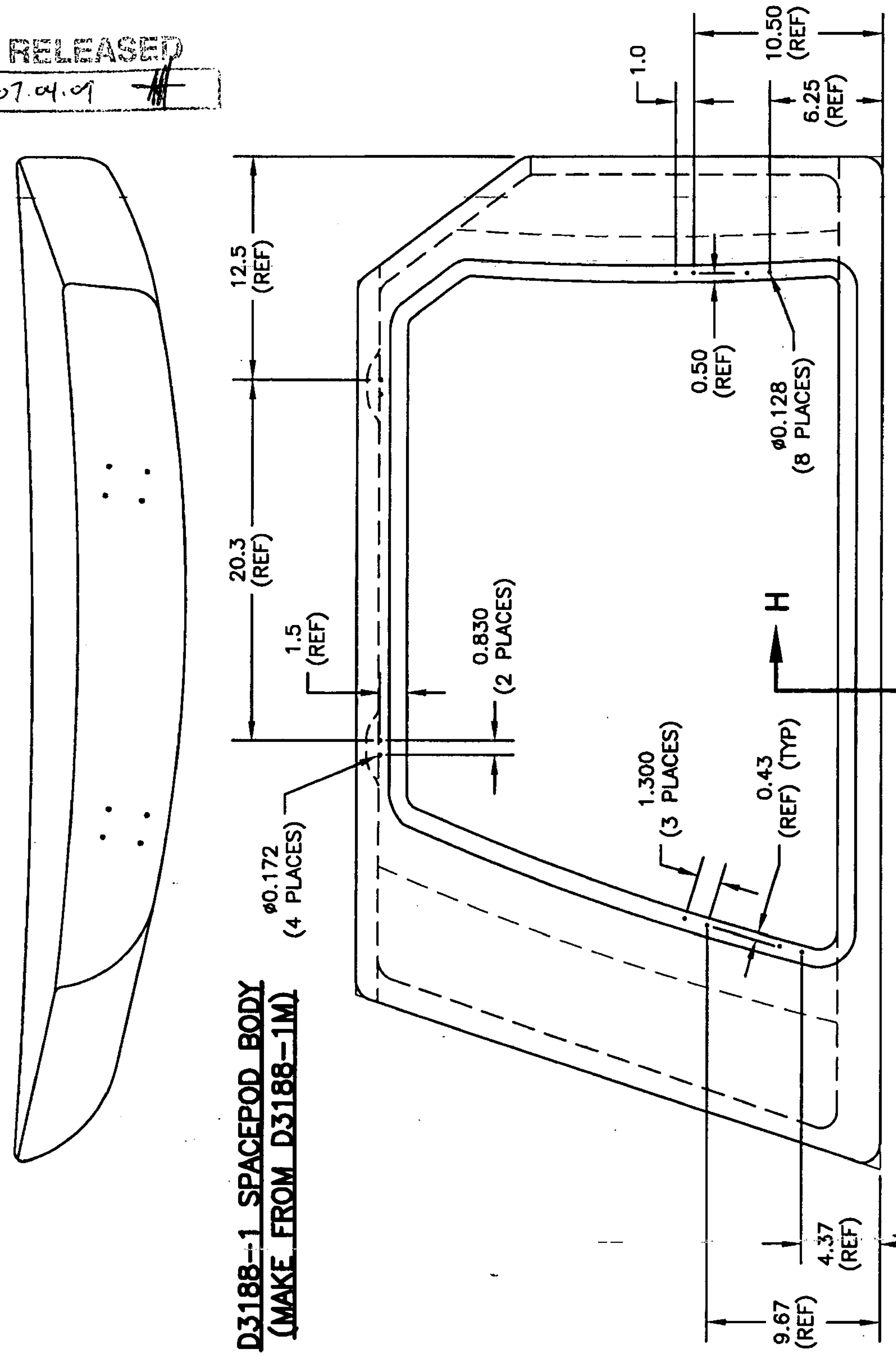
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA.
JB	CB	
CHECKED	APPROVED	DRAWING NO. D3188 · REV. E · SHEET 4 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY · SCALE NTS

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CB		
CHECKED	APPROVED	DRAWING NO.	REV. E
LE	[signature]	D3188	SHEET 5 OF 11
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS

RELEASED 07.04.09



D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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WORK ORDER NO. 31767

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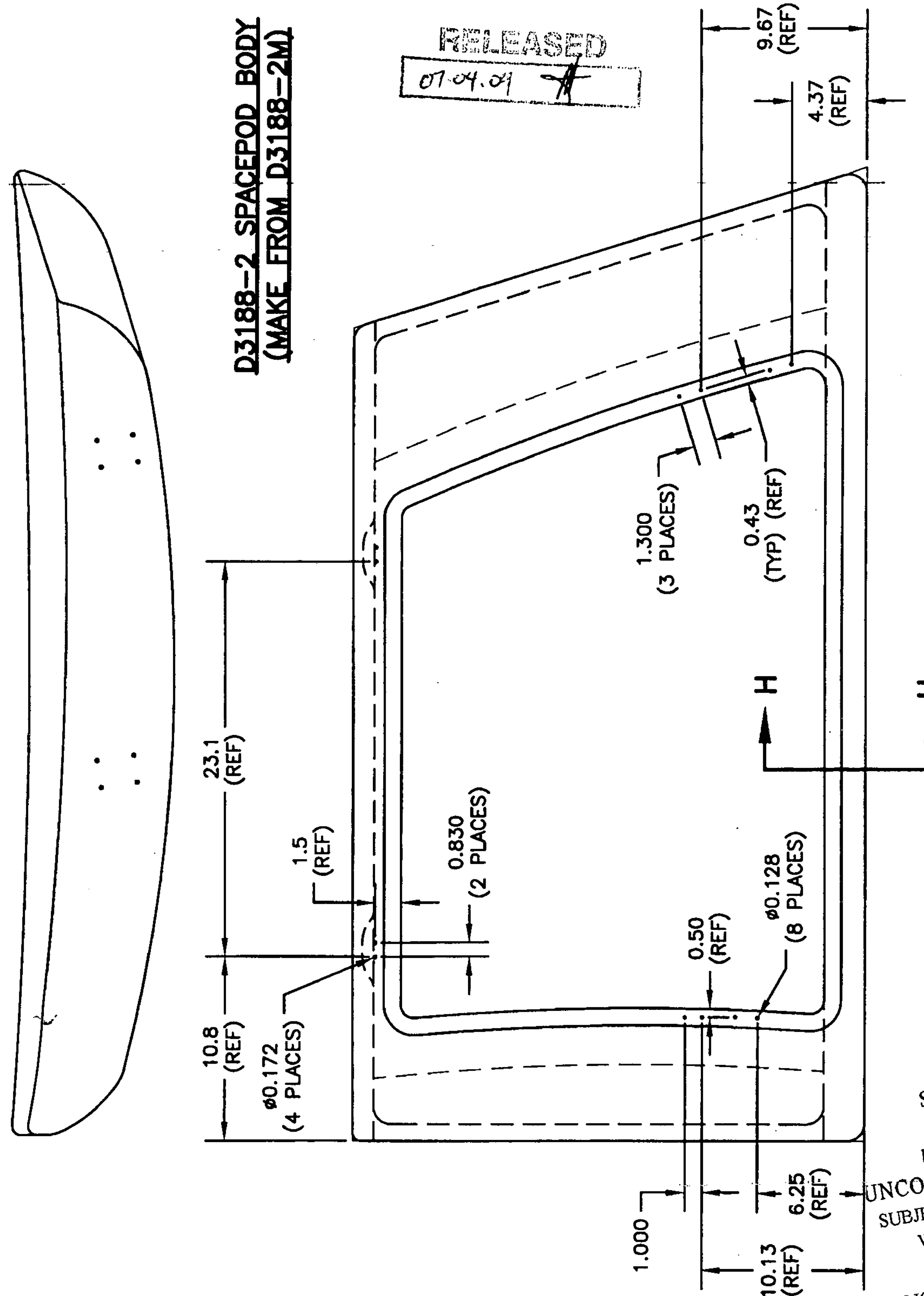
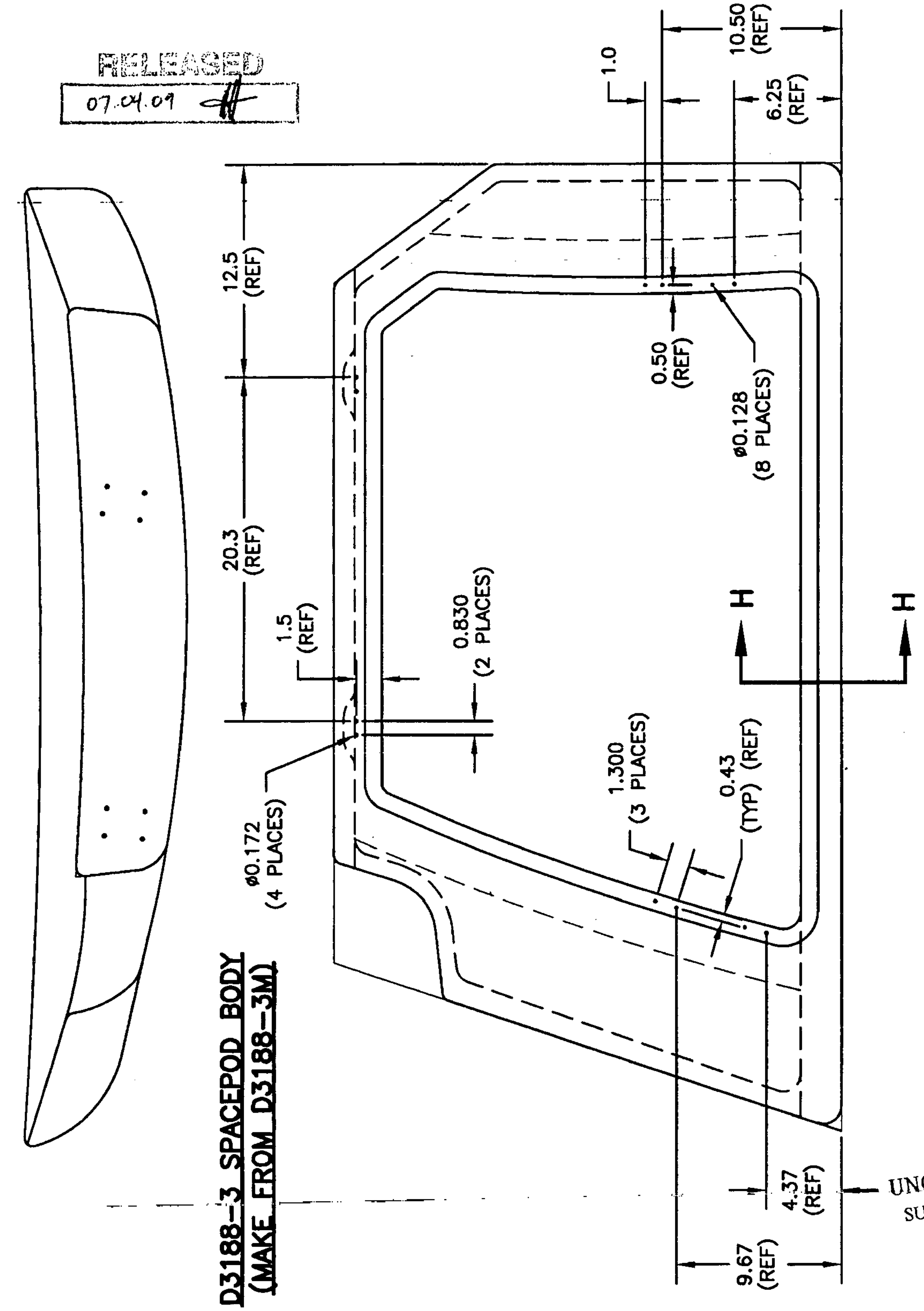
JB	CB		
CHECKED	APPROVED	DRAWING NO.	REV. E
LE	[signature]	D3188	SHEET 6 OF 11
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CB		
CHECKED	APPROVED	DRAWING NO.	REV. E
LE	[signature]	D3188	SHEET 7 OF 11
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS

RELEASED 07.04.09

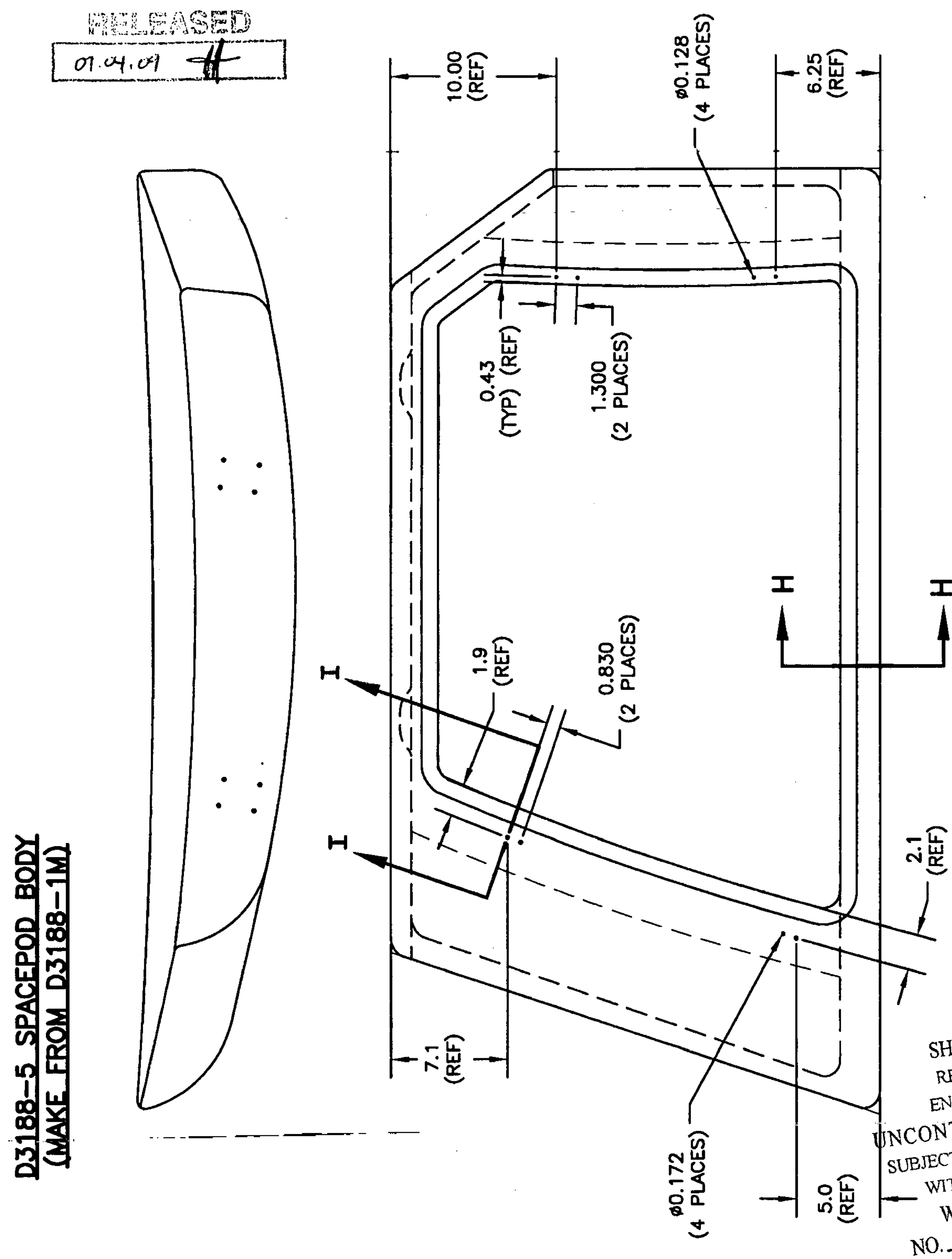


NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186–1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	CB		
CHECKED	APPROVED	DRAWING NO.	REV. E
LE	[signature]	D3188	SHEET 8 OF 11
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS

RELEASED 07.04.09



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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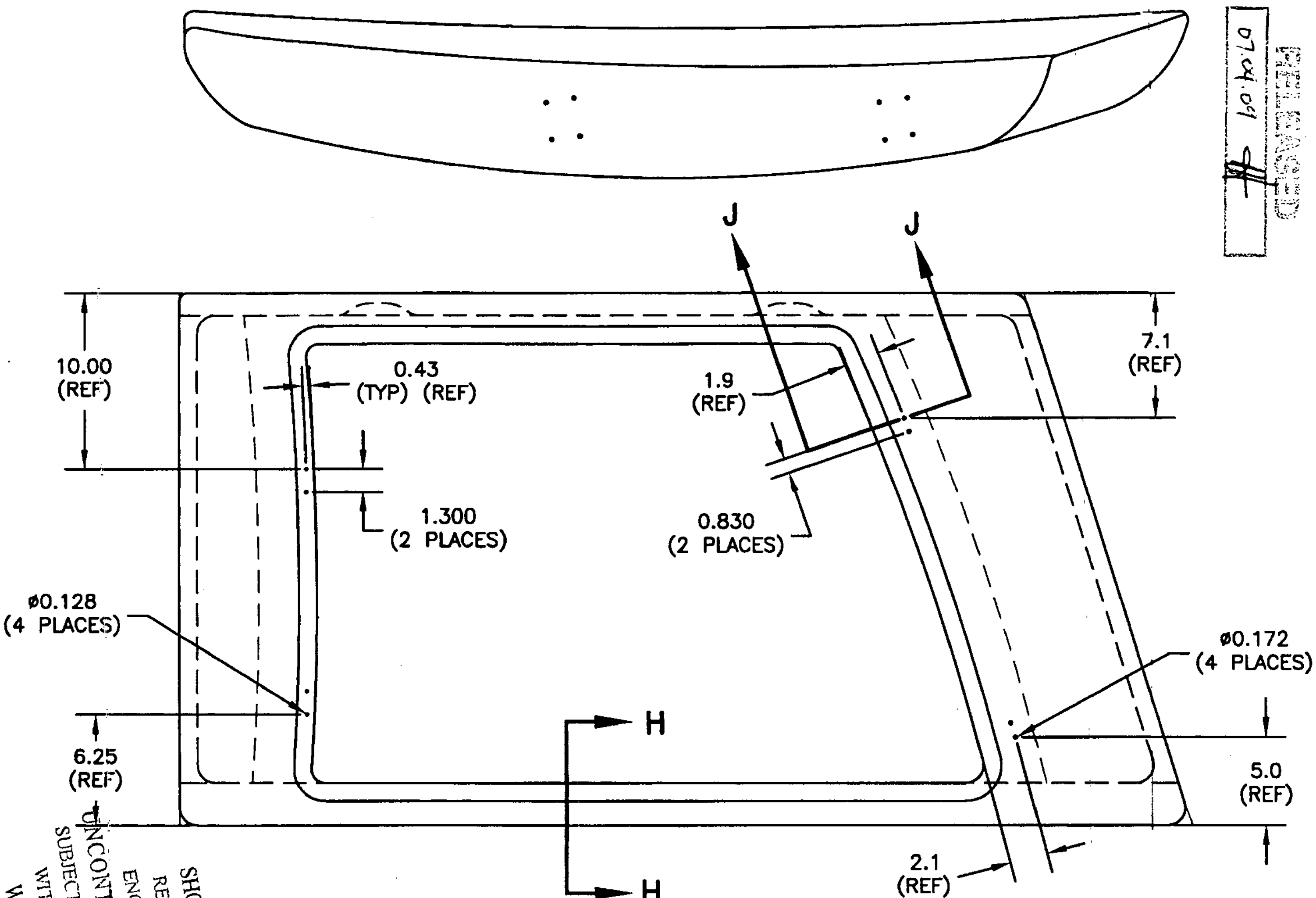
WORK ORDER NO. 31767

D3188-6 SPACEPOD BODY
(MAKE FROM D3188-2M)



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WITHOUT NOTICE
WORK ORDER
NO. 3176

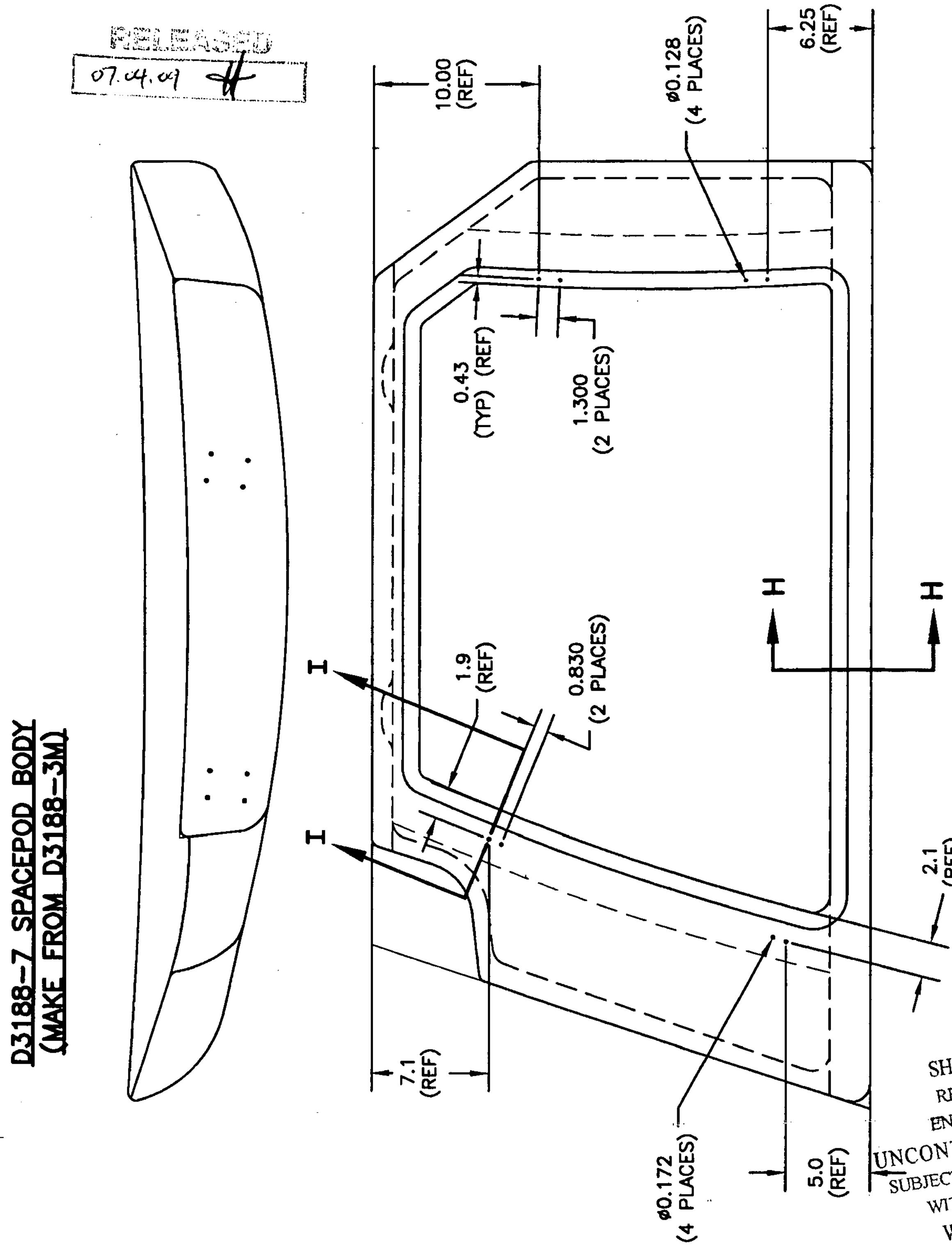
NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB	CB	
CHECKED	APPROVED	DRAWING NO. D3188 — REV. E
CE	[signature]	SHEET 9 OF 11
DATE 07.04.02		TITLE SPACEPOD BODY — SCALE NTS

DART

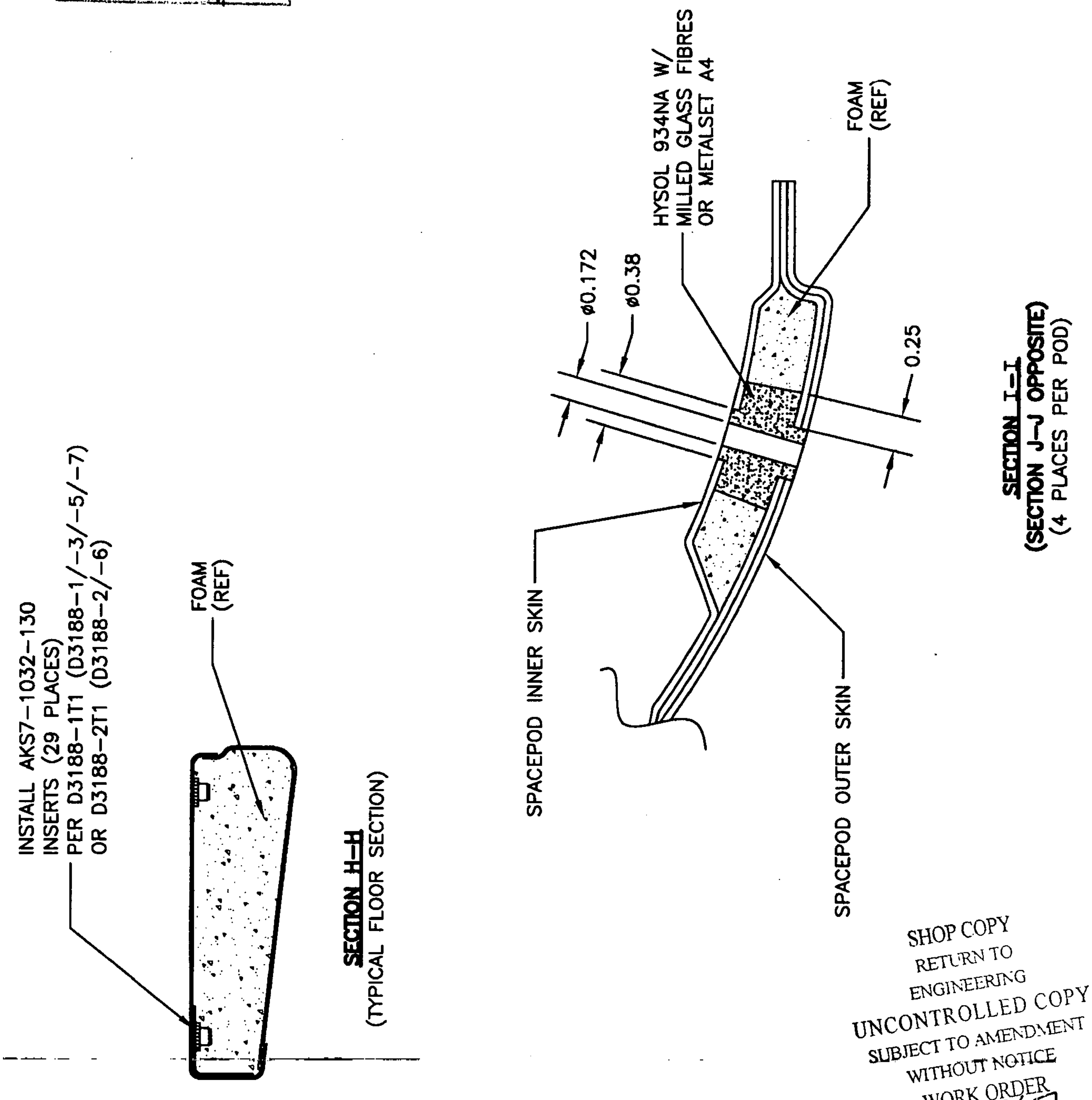
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB	CB	
CHECKED	APPROVED	DRAWING NO. D3188 — REV. E — SHEET 10 OF 11
LE		
DATE		TITLE — SCALE
07.04.02		SPACEPOD BODY — NTS



NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	C.B		
CHECKED	APPROVED	DRAWING NO.	REV. E
LE	[signature]	D3188	SHEET 11 OF 11
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS

DART



Dart Aerospace Ltd.

Date: Wednesday, 12/20/2006 1:45:10 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SPACEPOD BODY LH
Job Number	: 30024		
Estimate Number	: 12595		
P.O. Number	: N/A	**Part Number**	: D31881M
This Issue	: 12/20/2006 **S.O. No.** : N/A	**Drawing Number**	: D3188 REV B C LE 07.01.18
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : PURCHASED PARTS	**Drawing Revision**	: B C LE 07.01.18
Previous Run	: 30023	**Material**	: N/A
Written By	:	**Due Date**	: 1/25/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 061220		
Comment	: Est Rev:A New issue ecn882 06-11-30 EC		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	D2213	Aluminum Spacer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8 D2213 Spacer Batch: B25325 C 07/01/02 (8)

2.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: 2767 C 06/12/21 (1)
Description: D3188-1 BODY
Ship: D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

3.0	D31881P	Spacepod Body

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage.Ensure a copy of certification of conformity and process sheet from Delastek is attached. 07/04/10 (1)

 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes (No) **DQA:** [signature] **Date:** 07/04/27

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Date: Wednesday, 12/20/2006 1:45:10 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** SPACEPOD BODY LH

Job Number: 30024 **Part Number:** D31881M

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins. ml 07/04/12

Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA ml 07/04/12

Seq. #:	Machine Or Operation:	Description :
7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE (1) 07/04/27

Job Completion u 07.04.27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

GENERAL NOTES:

1. REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING
2. LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING
3. MATERIALS:

   RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

   FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
   12 oz UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
   18 oz ROVING "E" GLASS (18 oz CLOTH)
   OWENS CORNING MILLED FIBERS, "E" GLASS
   3M K20 GLASS BUBBLES

   FOAM: A500 CORE CELL
   OR DIVINYCELL
   OR AIREX
   OR KLEGECELL
   FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4. MOLD SHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5. APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4
6. FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S
7. ALL DIMENSIONS ARE IN INCHES
8. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 30024

RELEASED 06.12.22

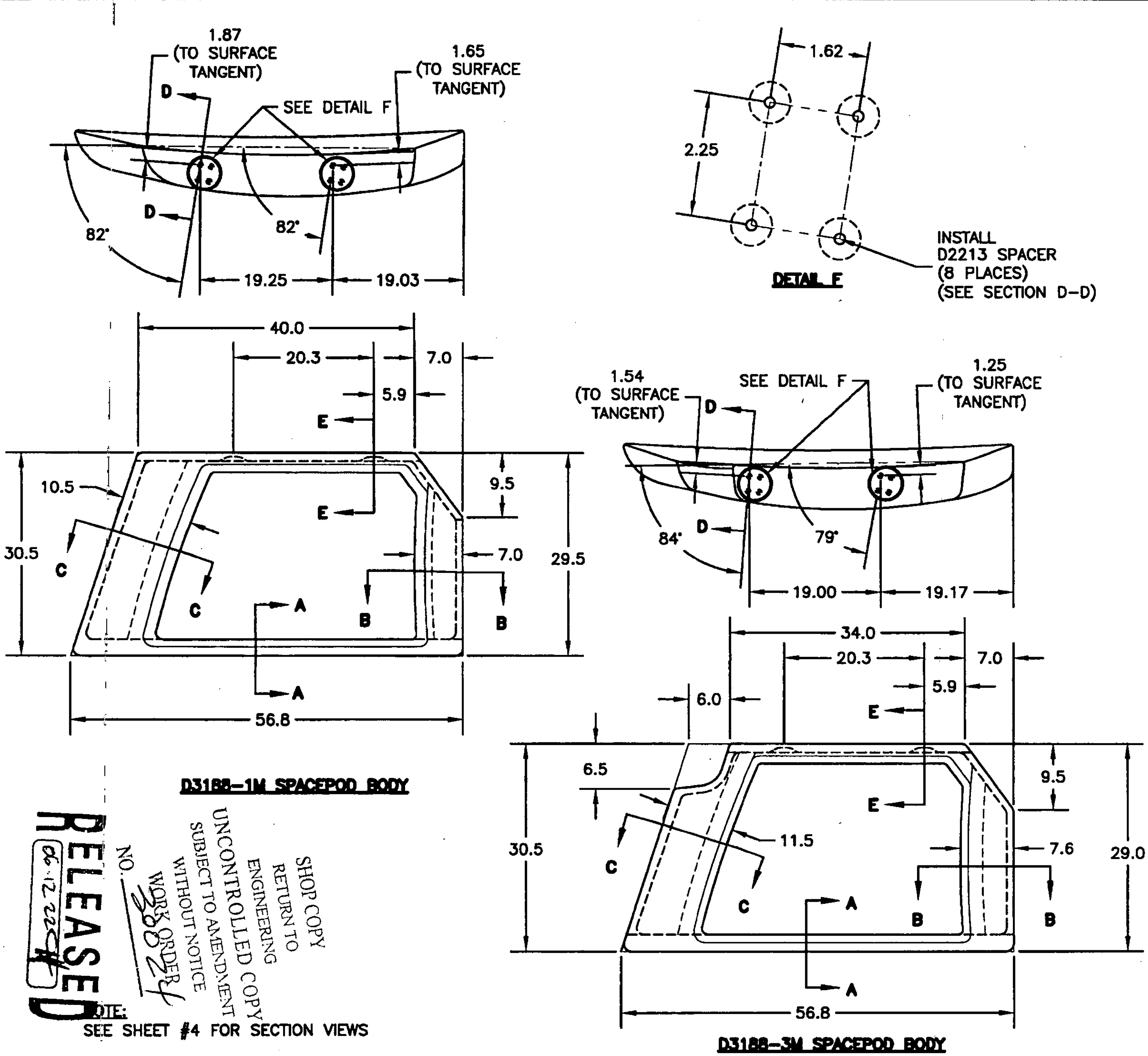
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
JB	[signature]	D3188	C

CHECKED	APPROVED	TITLE	SHEET
[signature]	[signature]	SPACEPOD BODY	1 OF 11

DATE	SCALE
06.12.13	NTS

REV	DATE	DESCRIPTION
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS



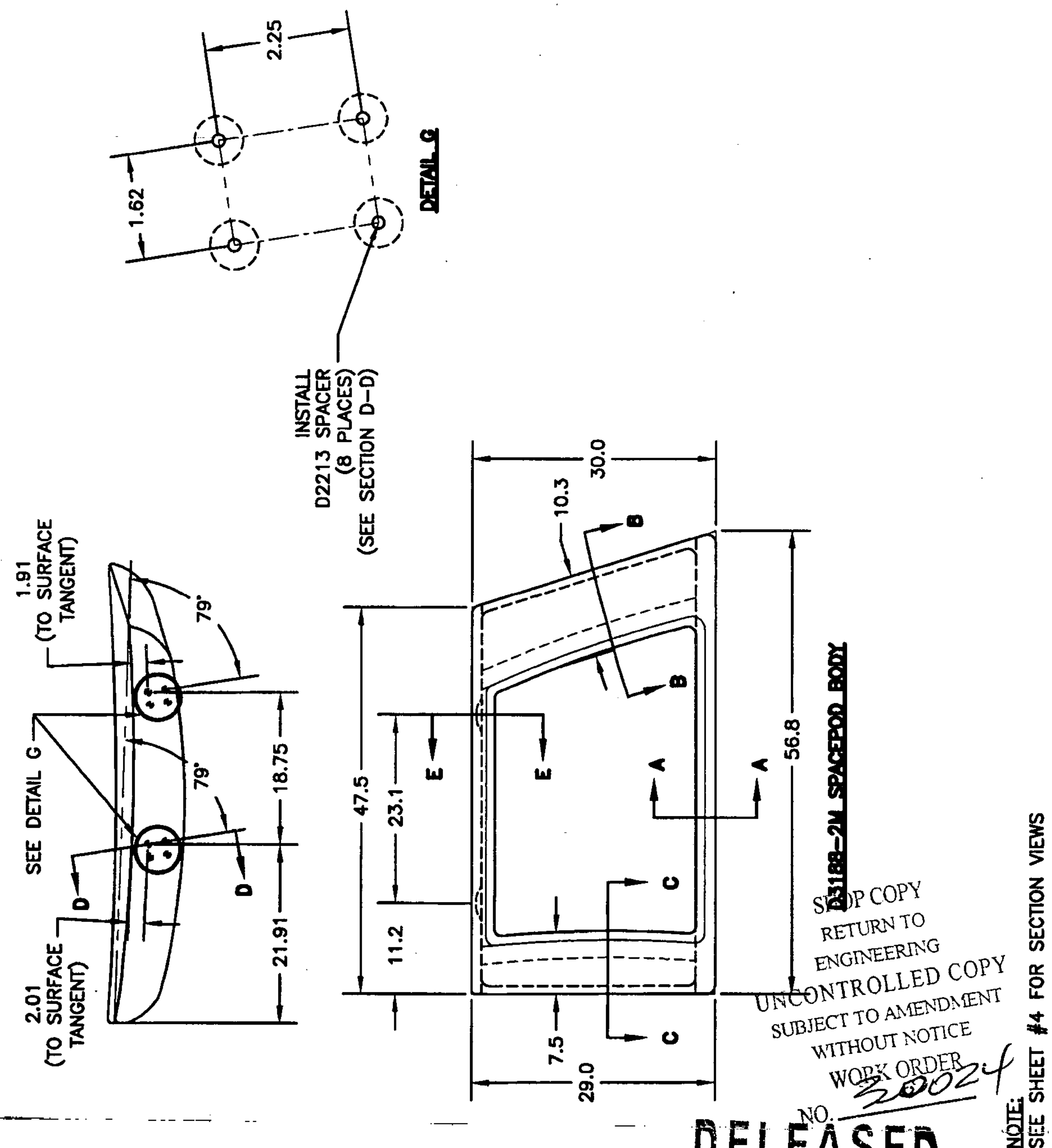
NOTE:
SEE SHEET #4 FOR SECTION VIEWS

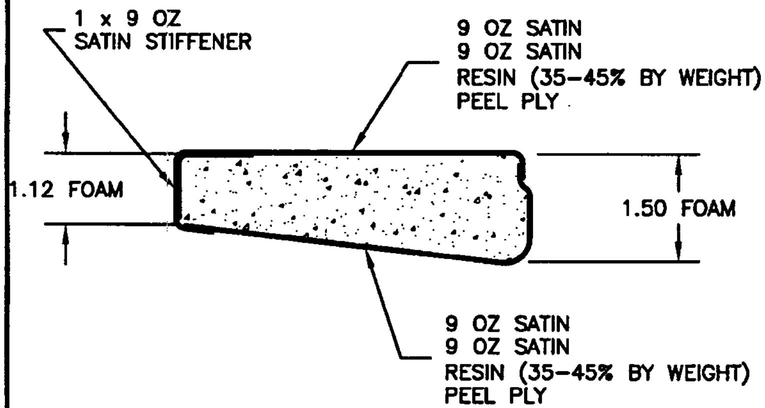
DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

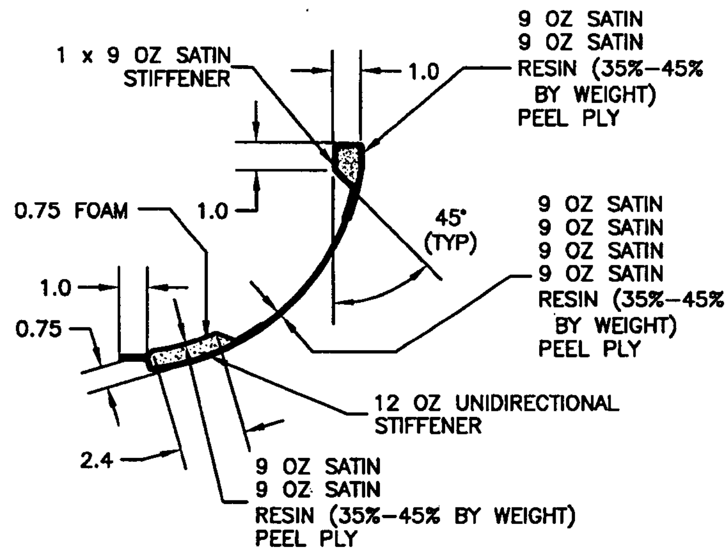
DESIGN	DRAWN BY		
JB	CE		
CHECKED	APPROVED	DRAWING NO.	REV. C
PH	[signature]	D3188	
DATE		TITLE	SHEET 2 OF 11
06.12.13		SPACEPOD BODY	SCALE NTS

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED JH	DRAWING NO. D3188 — REV. C — SHEET 3 OF 11
DATE 06.12.13		TITLE: SPACEPOD BODY — SCALE: NTS

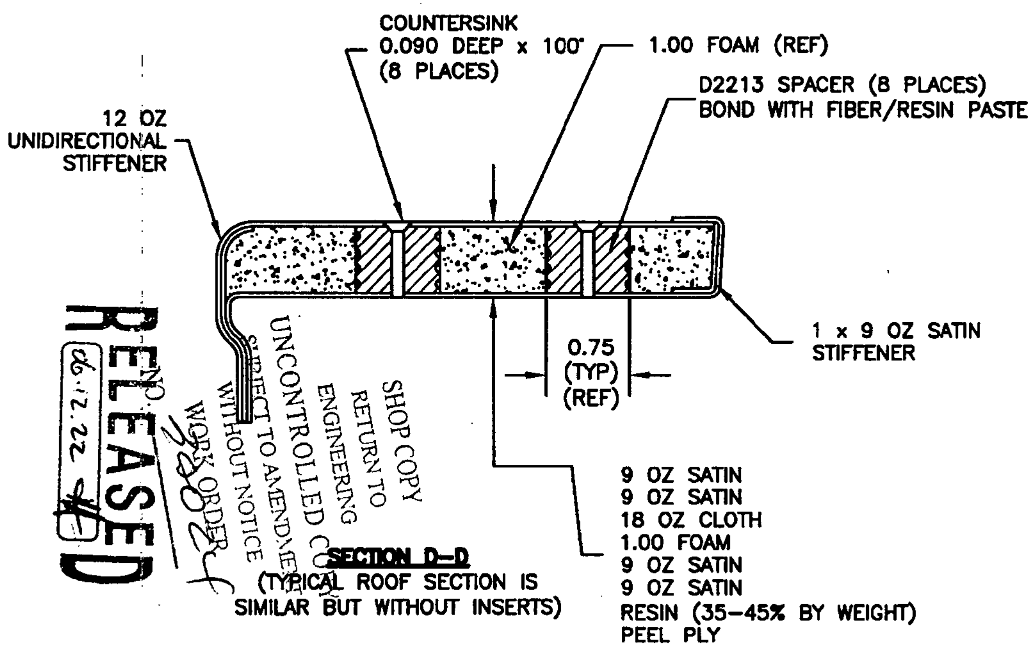




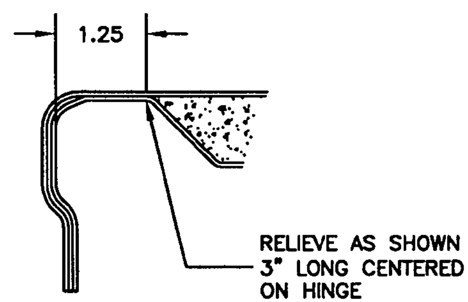
SECTION A-A
(TYPICAL FLOOR SECTION)



SECTION B-B
(SECTION C-C OPPOSITE)



SECTION D-D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E-E
(2 PLACES PER POD)

DART

DESIGN: JB	DRAWN BY: CE
CHECKED: PH	APPROVED: [illegible]
DATE: 06.12.13	

DART AEROSPACE LTD
"HAWKESBURY, ONTARIO, CANADA"

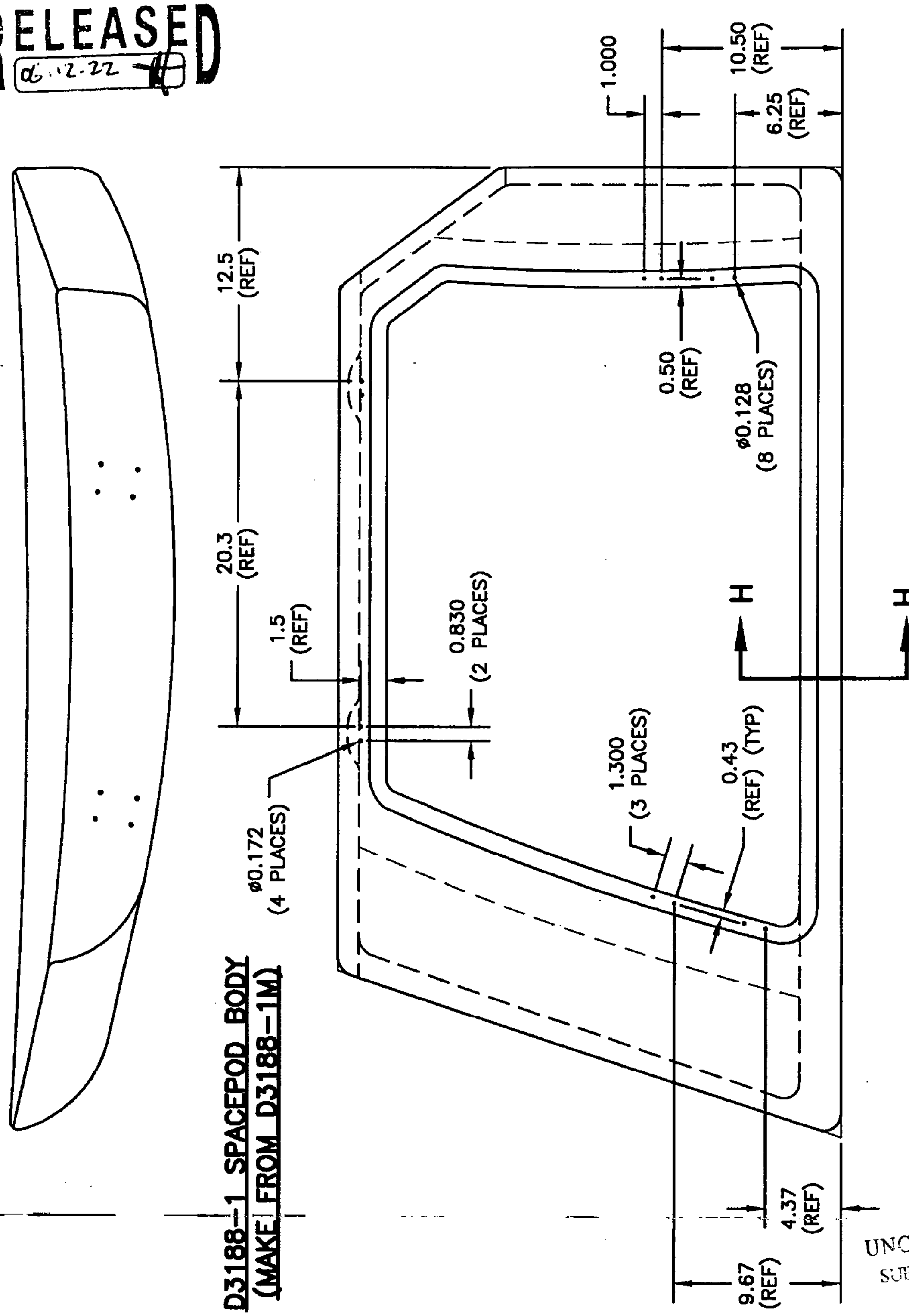
DRAWING NO. D3188 — REV. C — SHEET 4 OF 11

TITLE: SPACEPOD BODY — SCALE: NTS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB	LE	
CHECKED PH	APPROVED	DRAWING NO. D3188 — REV. C — SHEET 5 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY — SCALE NTS

DART

RELEASED 06.12.22



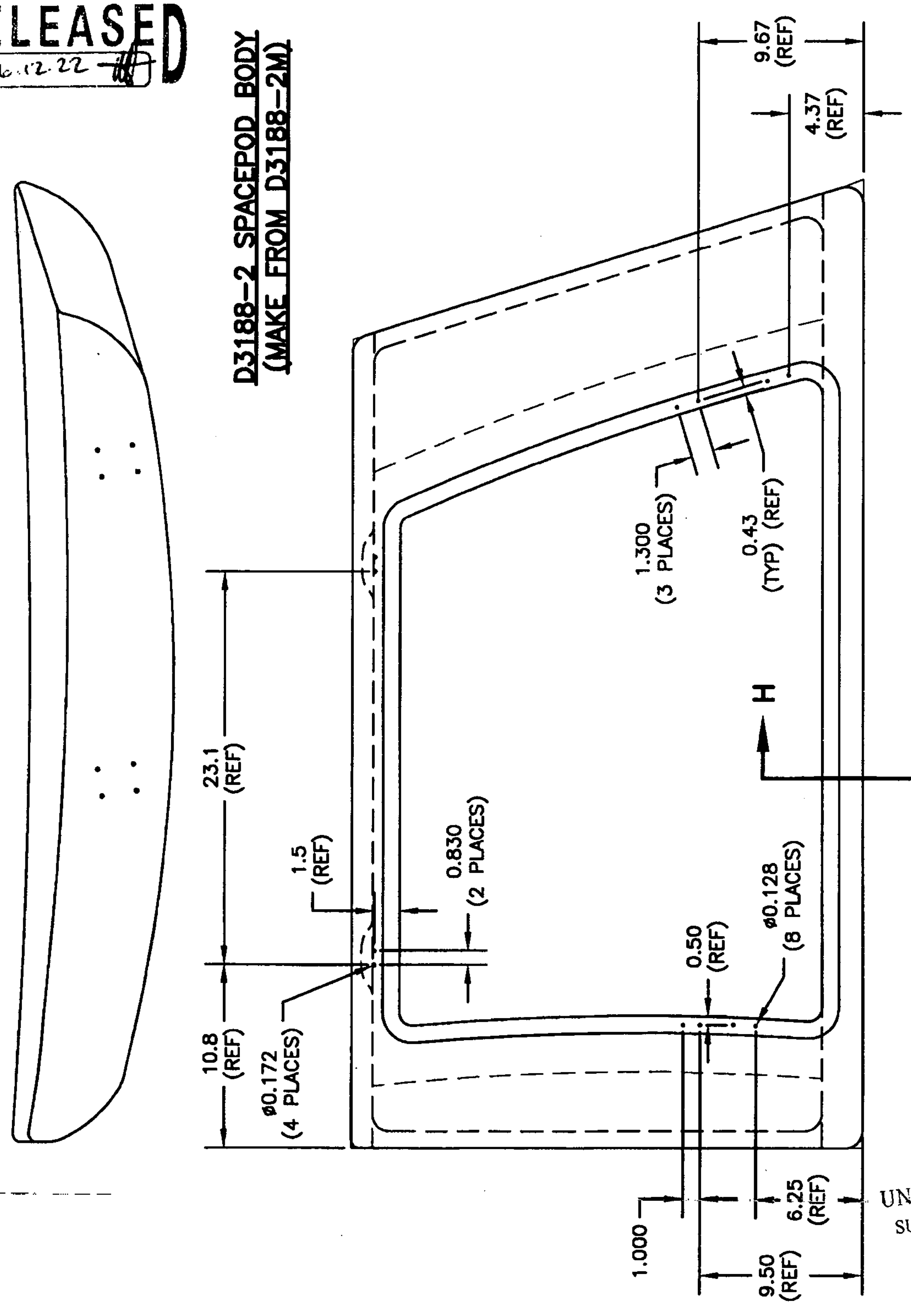
D3188-1 SPACEPOD BODY
(MAKE FROM D3188-1M)

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DART

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED	DRAWING NO. D3188 — REV. C — SHEET 6 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY — SCALE NTS

D3188-2 SPACEPOD BODY
(MAKE FROM D3188-2M)



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	LE	HAWKESBURY, ONTARIO, CANADA
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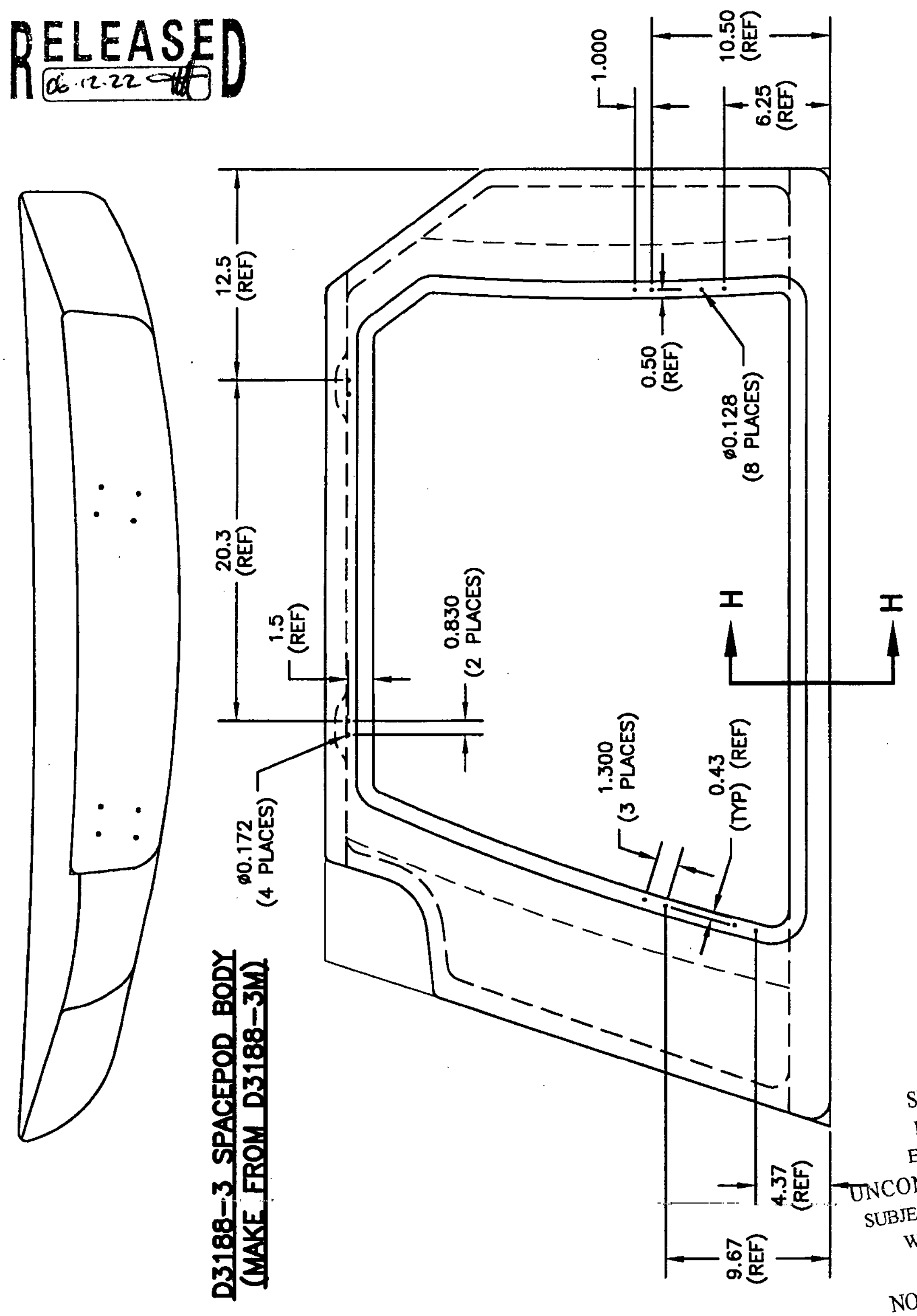
DATE 06.12.13		TITLE SPACEPOD BODY — SCALE NTS

RELEASED 06.12.22

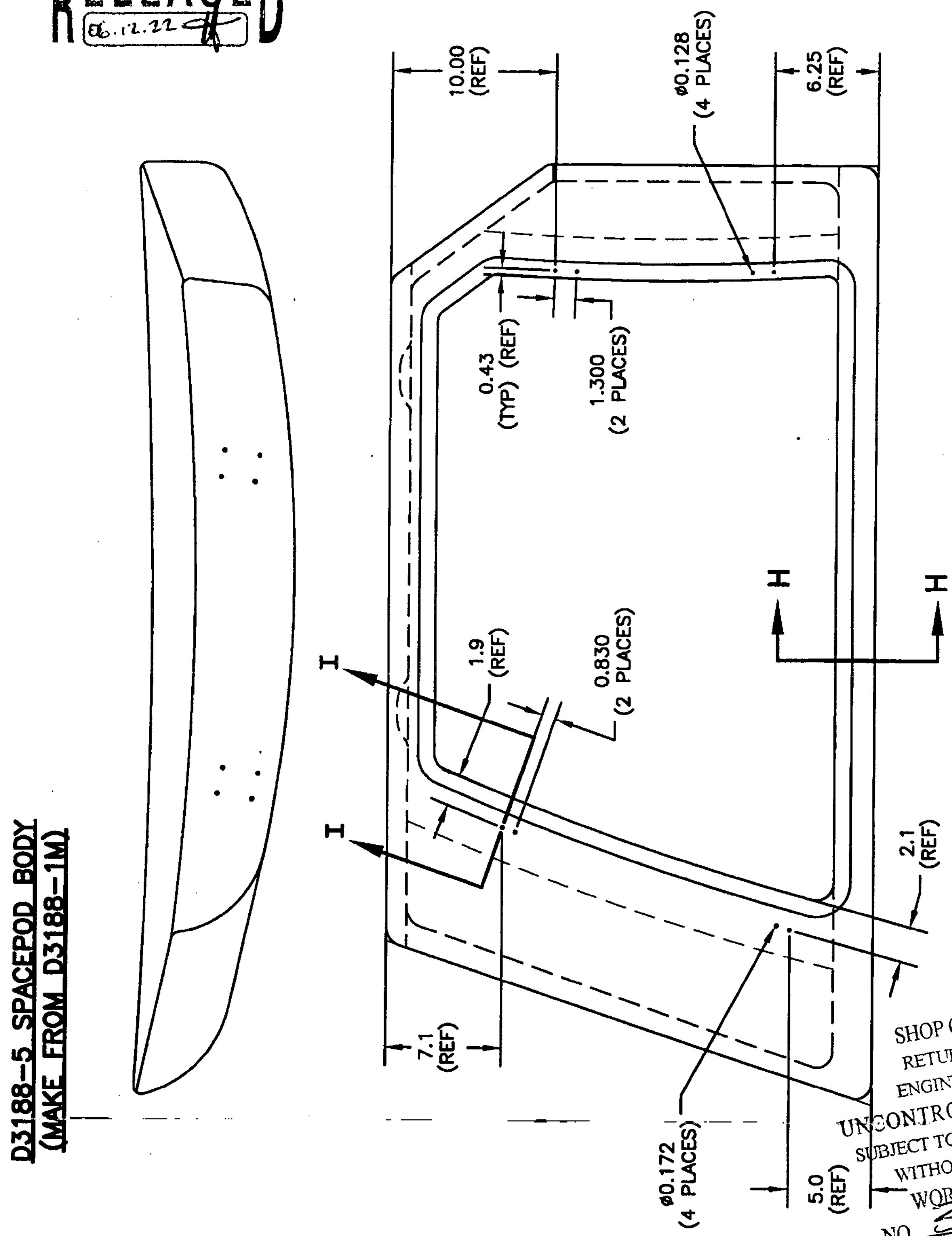


NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED	DRAWING NO. D3188 — REV. C — SHEET 8 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY — SCALE NTS

RELEASED 06.12.22



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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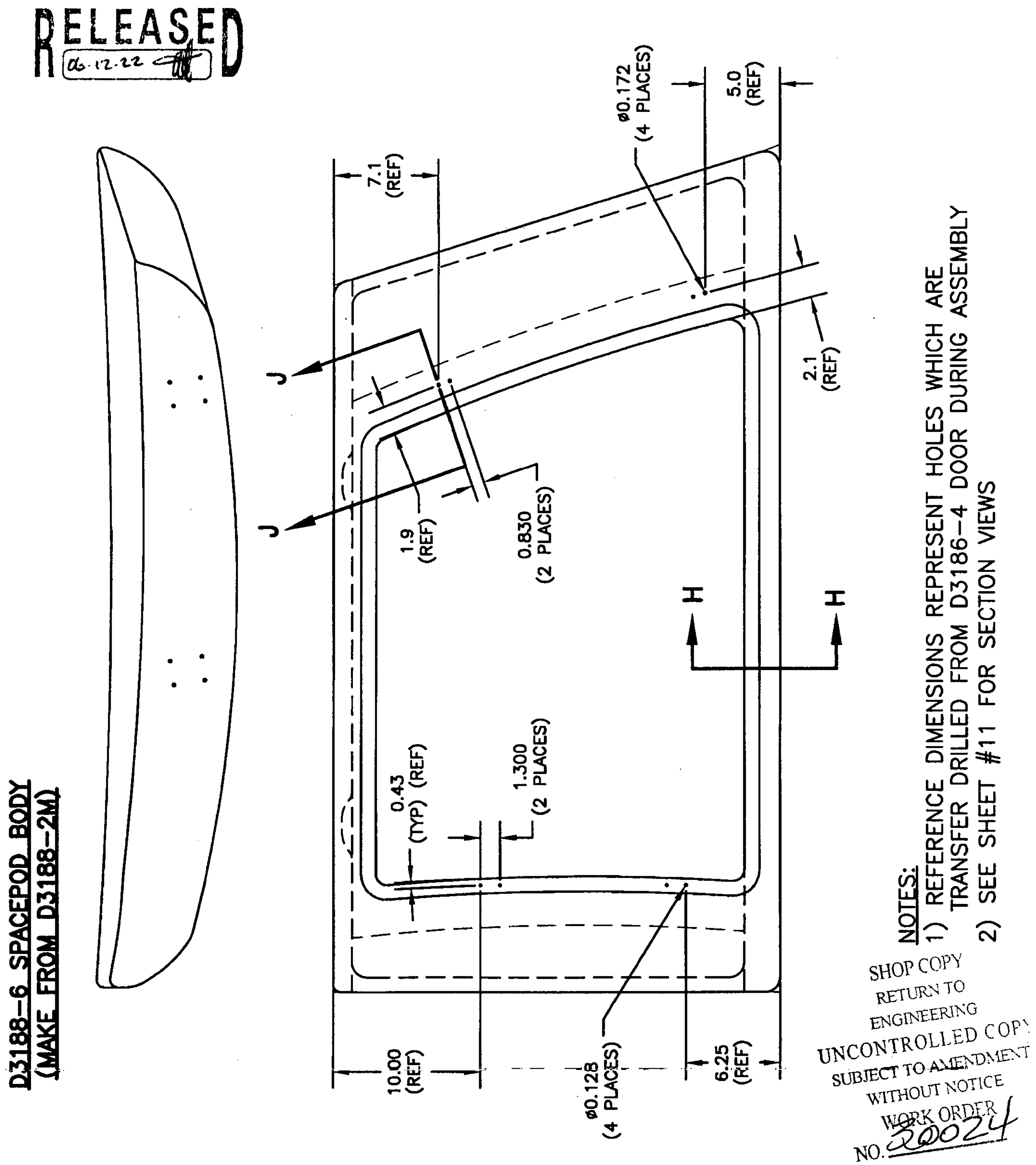
JB	LE	
CHECKED PH	APPROVED	DRAWING NO. D3188 — REV. C — SHEET 9 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY — SCALE NTS

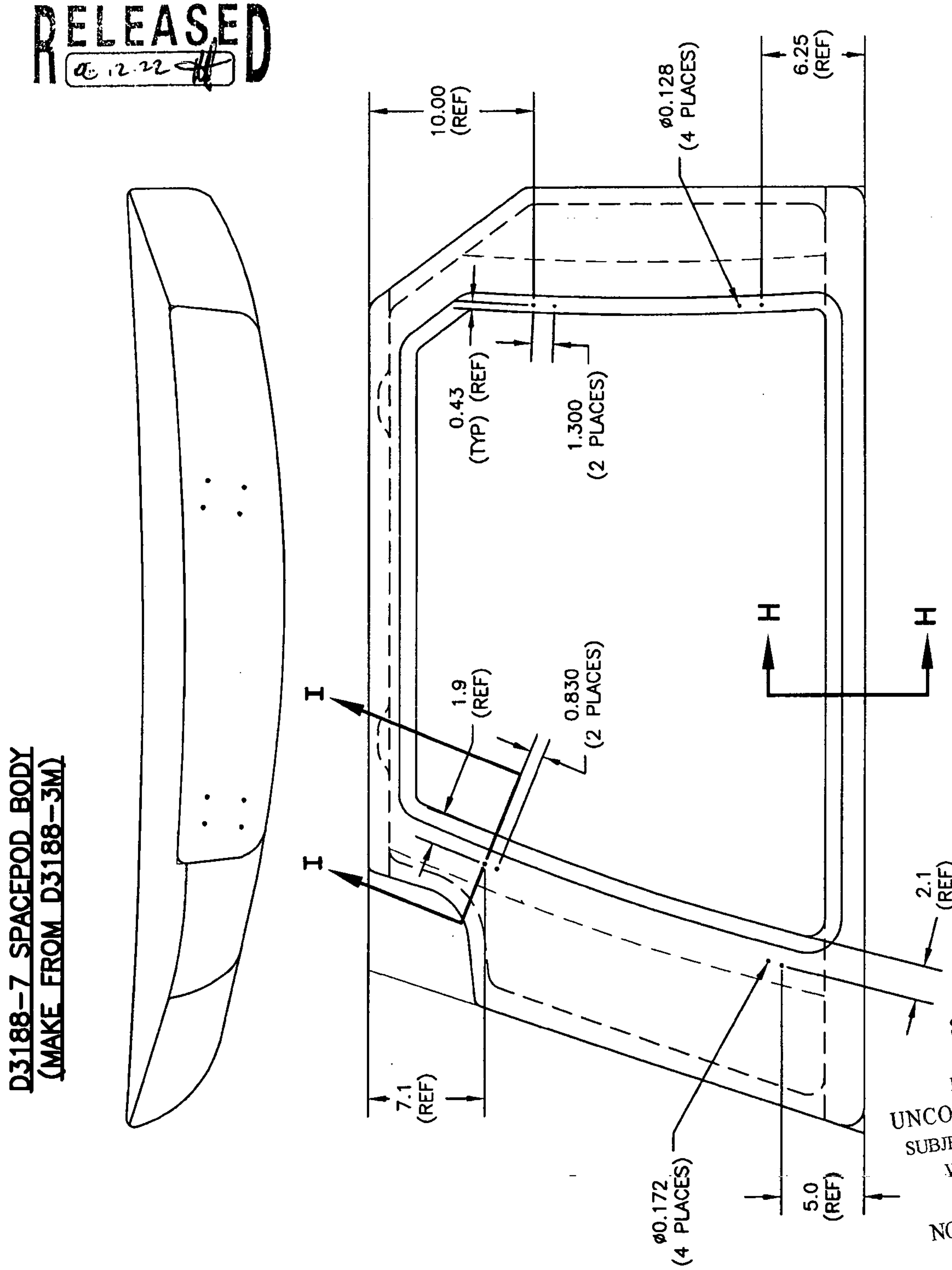
DART



DART

DESIGN JB	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3188	REV. C SHEET 10 OF 11
DATE 06.12.13		TITLE SPACEPOD BODY	SCALE NTS

RELEASED 06.12.22

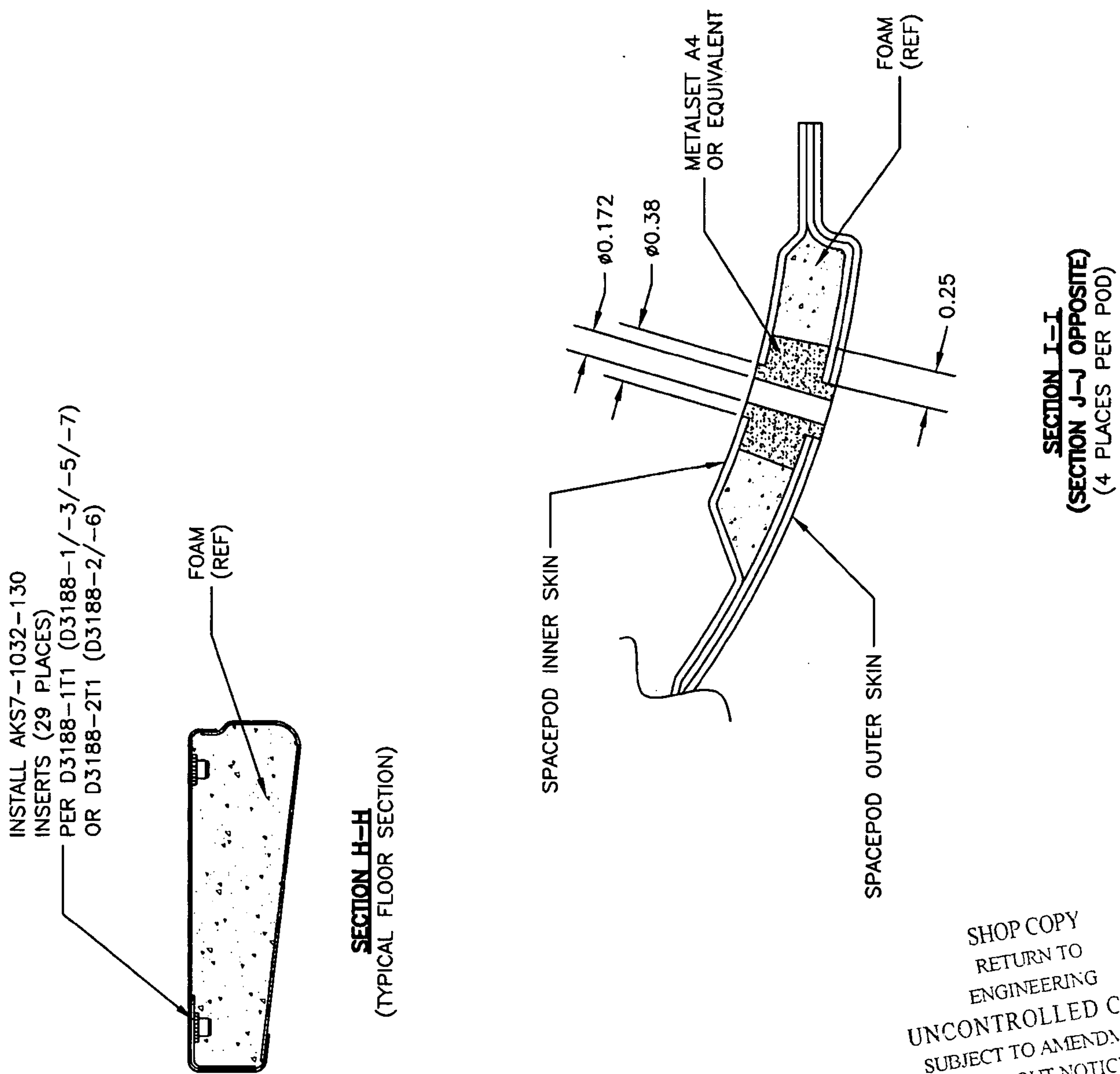


NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

SHOP COPY RETURN TO ENGINEERING
UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE
WORK ORDER NO. 30024

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3188 — REV. C — SHEET 11 OF 11
PH		
DATE		TITLE — SCALE
06.12.13		SPACEPOD BODY — NTS



PACKING SLIP
CERTIFICATE OF COMPLIANCE

DELASTEK COMPOSITES

DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

Invoice #	11809
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:	Ship to:
Dart Aerospace Ltd. 1270, Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada	Dart Aerospace Ltd. 1270, Aberdeen Street Hawkesbury, Ontario K6A 1K7 Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via	F.O.B.	Terms	Salesperson
EPIC EXPRESS COLLECT	Origin	Net30 days	Claude Lessard, ext. 233

Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #
04/04/07	21/12/06	5092	C. Lavoie	PO00002767	

Order Qty	B.O. Qty	Current Ship	Item #	Item Description	
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30014 Dwg. Rév.: C Job: 41247	U de M : Each
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30024 Dwg. Rév.: C Job: 41093	U de M : Each
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30034 Dwg. Rév.: C Job: 41249	U de M : Each
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30044 Dwg. Rév.: C Job: 41094	U de M : Each

07/04/10

ML 07/04/12

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: ____________
Quality department AQ-357

DELASTEK COMPOSITE QA-2

☑ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Feuille de Procédé

Client	: DART Dart Aerospace Ltd.	**Nom Dessin**	: SPACEPOD BODY
Numéro Job	: 41093	**Numéro Article**	: DKC134-0053
Numéro Soumission	: 2585	**Numéro Dessin**	: D3188
Numéro B.A.	:	**Projet Numéro**	: DKC134
Cette fois	: 2007-02-28 **No. B.V.** :	**Révision dessin**	: B
Prsht Rev.	: NC	**Matériel**	: Fibre 7781 et Résine 411-350
Prem. fois	: - - **Type** :	**Date Dûe**	: 2007-03-07 **Qté:** 1 **UdM:** UNITE
Job précédente	: 41032		

Écrit par : ______________________ (DELASTEK COMPOSITE 15)

Vérifié & Approuvé par : ______________________

Commentaires : N° de pièce Dart Aerospace : D31881M
N° de Projet Delastek: DK-362

Process Sheet Rev.: 00 Création du premier à partir du
DKC134-0019

Produit additionnel

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8003 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 05/03/07 Heure Début:________ Heure Fin:________ Sceau: (DELASTEK COMPOSITES 62)

3.0	AC0409	Tissu à délaminer Release ply B

Commentair Qty.: 9.84 VERGE(s)/Unit Total : 9.84 VERGE(s)
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3

Commentair Qty.: 9.27 VERGE(s)/Unit Total : 9.27 VERGE(s)
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10

Commentair Qty.: 6.00 VERGE(s)/Unit Total : 6.00 VERGE(s)
Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert

Commentair Qty.: 7.00 VERGE(s)/Unit Total : 7.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD BODY
Numéro Job: 41093 **Numéro Article:** DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
7.0	AAC0326	9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 11.4 VERGE(s)/Unit Total : 11.4 VERGE(s)
9.7 oz 7781 Weave "S" glass #FG-778150-125Y N° de Lot: 1-5905-1

8.0	AC0098	Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 4.0000 RL(s)/Unit Total : 4.0000 RL(s)
Ruban à gommer jaune #: T/AT-200Y

9.0	AAC0443	Fiberglass 12 oz Unidirectional

Commentair Qty.: 0.80 VERGE(s)/Unit Total : 0.80 VERGE(s)
Fiberglass 12 oz Unidirectional N° de Lot: 5455

10.0	AAC0633	WR1850 ROVING 18 OZ x 50"

Commentair Qty.: 0.35 VERGE(s)/Unit Total : 0.35 VERGE(s)
WR1850 ROVING 18 OZ x 50" N° de Lot: 1-5873-1

11.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe et les quantités inscrites sur ceux-ci.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 2/03/07 Heure Début:________ Heure Fin:________ Sceau: [DELASTEK COMPOSITES 32]

12.0	AAC0275	Catalyst N° DDM-9

Commentair Qty.: 0.0640 PINTE(s)/Unit Total : 0.0640 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 5921

13.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 2.000 KILOGRAMME(s)/Unit Total : 2.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6015-1

14.0	AAC0673	Fibre de verre Miapoxy 66

Commentair Qty.: 0.0039 GALLON(s)/Unit Total : 0.0039 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot: 1-5502-1

15.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Nom Dessin: SPACEPOD BODY
Numéro Job: 41093
Numéro Article: DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :

Préparer une seringue rempli de 30 ml de résine chargé de fibre dde verre Mia Poxy 66.

Date: 5/03/07 Heure Début:_______ Heure Fin:_______ Sceau:_______ DELASTEK COMPOSITES 65

16.0	LAMINAGE.	LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide de la seringue. Faire un joint tout autour de la dénivellation pour la porte directement dans le moule.

À l'aide d'un rouleau 2" dia. appliquer une couche de résine.N° 411-350 sur le moule N° DT 8003 et ensuite imbiber un pli de tissu 9.7oz.et un 18 oz. sur la section supérieur de la pièces.

Laminage du 12 oz.

Recommencer l'opération pour le deuxième pli.

Date: 5/03/07 Heure Début:_______ Heure Fin:_______ Sceau:_______ DELASTEK COMPOSITES 65 DELASTEK COMPOSITES 62 DELASTEK COMPOSITES 32

17.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LA POCHE À VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer
2- Film Perforé P-3
3- Feutre de drainage.
4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures Minimum.

Date: 5/03/07 Heure Début:_______ Heure fin:_______ Sceau:_______ DELASTEK COMPOSITES 32 DELASTEK COMPOSITES 62 DELASTEK COMPOSITES 65

Curing Début:___________ Curing Fin:___________

18.0	AAC0457	ATC core-cell A500 plain 4'x8' 1" thick

Commentair Qty.: 0.75 FEUILLE(s)/Unit Total : 0.75 FEUILLE(s)

ATC core-cell A500 plain 4'x8' 1" thick Selon dessin D3188 de Dart

N° de Lot: 1-5836-1

Date: Mercredi, 2007-02-28 15:16:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD BODY
Numéro Job: 41093 **Numéro Article:** DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
19.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 120.0000Min Total Run : 2.0000Hrs
TAILLAGE DU MATÉRIEL

Tailler et le Foam Core 1" selon plan de découpe et gabarits

Date: 9/03/07 Heure Début:_______ Heure Fin:_______ Sceau: DELASTEK COMPOSITES 62 DELASTEK COMPOSITES 32

20.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.200 KILOGRAMME(s)/Unit Total : 0.200 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

21.0	AAC0275	Catalyst N° DDM-9

Commentair Qty.: 0.0064 PINTE(s)/Unit Total : 0.0064 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

22.0	FINITION 3	FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART 9/03/07 DELASTEK COMPOSITES 32 DELASTEK COMPOSITES 62

Prendre les deux pièces de 11" x 57" et sceller 1 grande surface sur chacune d'elle selon I.G. # Sceller le Foam Core.

23.0	AAC0452	Polybond B46F

Commentair Qty.: 0.010 KIT(s)/Unit Total : 0.010 KIT(s)
Polybond B46F

N° de Lot: 1-5865-1

24.0	FINITION 3	FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

À l'aide de polybond, coller ensemble les deux surfaces scellées

Disposer des poids sur les pièces pour conserver une pression de collage.

Laisser sécher 2 heures minimum.

Quantité: 1 Date: 9/03/07 Sceau: DELASTEK COMPOSITES 32 DELASTEK COMPOSITES 62

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD BODY
Numéro Job: 41093 **Numéro Article:** DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :

Quantité:________ Date:________ Sceau:________

25.0	TRIMAGE 3	TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Ajuster chacune des pièces de foam core dans le moule selon le dessin.

Quantité: 1 Date: 12/03/07 Sceau: DELASTEK COMPOSITES 62

Quantité:________ Date:________ Sceau:________

26.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot.: 1-6032-1

27.0	AAC0275	Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

28.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
PRÉPARATION DU MATÉRIEL DART 12/03/07 DELASTEK COMPOSITES 62

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350 promoté 75 minutes..

29.0	FAB GÉNÉRALE 3	FABRICATION GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
FABRICATION GÉNÉRALE DART

Retirer les pièces de foam core du moule

Sceller les foam core à l'aide de la résine promoté N° 411-350 75 minutes. Selon I.G. # Sceller le Foam Core

Laisser sécher pendant 2 heures minimum DELASTEK COMPOSITES 62 DELASTEK COMPOSITES 32

Date: 12/03/07 Sceau:________ Initiales:________

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41093
Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
30.0	AAC0452	Polybond B46F

Commentair Qty.: 0.078 KIT(s)/Unit Total : 0.078 KIT(s)
Polybond B46F N° de Lot: 1-5865-1

31.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation du Polybond.

Date: 13/03/07 Heure Début:________ Heure Fin:________ Sceau: DELASTEK COMPOSITES 62

32.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Coller les différents pièces de Foam Core dans les Spacepod Body à l'aide du Poly bond.

Date: 13/03/07 Heure Début:________ Heure Fin:________ Sceau: DELASTEK COMPOSITES 62 / DELASTEK COMPOSITES 32 / DELASTEK COMPOSITES 65

33.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer,
2- Feutre de drainage
3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirer le bagging entre 1 heure et 1 heure 1/2 après le mélange de la résine afin d'enlever le surplus de polybond avant que celui-ce ne soit complétement polymérisé

Date: 13/03/07 Heure Début:________ Heure Fin:________ Sceau: DELASTEK COMPOSITES 62 / DELASTEK COMPOSITES 32 / DELASTEK COMPOSITES 65

Curing Début:___________ Curing Fin:___________

Form: rprocess

Date: Mercredi, 2007-02-28 15:16:45
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD BODY
Numéro Job: 41093 **Numéro Article:** DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
34.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6005-1

35.0	AC0059	Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

36.0	FINITION 3	FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FINITION GÉNÉRALE

Corriger les petits défauts de surface de la pièce avec du Sikkens. Pour les plos gros défauts, utiliser du polybond.

Date: 16/03/07 Heure Début:________ Heure Fin:________ Sceau:________ DELASTEX COMPOSITES 32 DELASTEX COMPOSITES 62

37.0	TRIMAGE 3	TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
TRIMAGE COMPOSITES DART

Tailler le foam core afin d'ajuster le contour de la pièce à celui du moule. 16/03/07 DELASTEX COMPOSITES 62

38.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.100 KILOGRAMME(s)/Unit Total : 0.100 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

39.0	AAC0275	Catalyst N° DDM-9

Commentair Qty.: 0.0032 PINTE(s)/Unit Total : 0.0032 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

40.0	FINITION 3	FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sceller le foam core qui a été exposé suite au taillage précédent selon I.G. # Sceller le fom Core

Laisser sécher pendant 2 heures minimum.

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41093
Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:

 # Séq.: **Machine ou Opération:** **Description :**

Quantité: 1 Date: 19/03/07 Sceau: DELASTEK COMPOSITES 62

Quantité:______ Date:______ Sceau:______

41.0 AAC0275 Catalyst N° DDM-9

Commentair Qty.: 0.0504 PINTE(s)/Unit Total : 0.0504 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

42.0 AAC0324 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.500 KILOGRAMME(s)/Unit Total : 1.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

43.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 19/03/07 Heure Début:______ Heure Fin:______ Sceau: DELASTEK COMPOSITES 62

44.0 LAMINAGE. LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Laminer deux pli de 9.7 oz 7781 S-Glass partout dans le moule.

Le laminage doit être fait à l'aide de la résine N° 411-350 / 2% DDM-9.

Date: 19/03/07 Heure Début:______ Heure Fin:______ Sceau: DELASTEK COMPOSITES 62 DELASTEK COMPOSITES 32 DELASTEK COMPOSITES 65

45.0 POCHE À VIDE 1 FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer,
2- Film perforé P-3,
3- Feutre de drainage

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41093

Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :

4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 19/03/07 Heure Début:________ Heure Fin:________ Sceau:________

Curing Début:____________ Curing Fin:____________

46.0 DÉMOULAGE 1 — DÉMOULAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
DÉMOULAGE DES PIECES

Démouler la pièce en se servant de la prise d'air sous le moule en faisant bien attention de ne pas abimer les différentes surfaces de la pièce.

Date: 20/03/07 Heure Début:________ Heure Fin:________ Sceau:________

47.0 TRIMAGE 3 — TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 60.0000Min Total Run : 1.0000Hrs
TRIMAGE DE FINITION

Percer les 8 trous sur la section supérieur de la pièce ainsi que l'ouverture pour la porte à l'aide du gabarit de N° DT5801.

Par l'intérieur, percer les 8 dégagement de ø .745" pour les spacers. (Ne pas percer la peau extérieur de la pièce)

Date: 20/03/07 Heure Début:________ Heure Fin:________ Sceau:________

48.0 AAC0275 — Catalyst N° DDM-9

Commentair Qty.: 0.0048 PINTE(s)/Unit Total : 0.0048 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 592/

49.0 AAC0324 — Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.150 KILOGRAMME(s)/Unit Total : 0.150 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

Date: Mercredi, 2007-02-28 15:16:46
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD BODY
Numéro Job: 41093 **Numéro Article:** DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
50.0	AAC0673	Fibre de verre Miapoxy 66

Commentair Qty.: 0.0420 GALLON(s)/Unit Total : 0.0420 GALLON(s)
Fibre de verre Miapoxy 66

N° de Lot.: 1-5502-1

51.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 21/03/07 Heure Début:_______ Heure Fin:_______ Sceau: DELASTEK COMPOSITES 65

52.0	AAC0448	Spacer N° D2213

Commentair Qty.: 8 UNITE(s)/Unit Total : 8 UNITE(s)
Spacer N° D2213 N° de Lot: 1-5949-1

53.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 45.0000Min Total Run : 0.7500Hrs
ASSEMBLAGE GÉNÉRALE DES PIECES

Faire l'assemblage des inserts (Spacer) N° D2213 dans les trous prévus à cet effet à l'aide de résine N° 411-350 chargé à l'aide de Fibre de verre Miapoxy 66

Laminer une pieće de 9 oz. sur chacune des 2 zones de 4 spacers.pour reboucher les trous.

Appliquer un pression sur les pièces de 9 oz. à l'aide d'un bloc de bois et de pinces autoblocantes.

Laisser sécher pendant 4 heures minimum.

Date: 21/03/07 Heure Début:_______ Heure Fin:_______ Sceau: DELASTEK COMPOSITES 65

Curing Début:__________ Curing Fin:__________

54.0	AAC0275	Catalyst N° DDM-9

Commentair Qty.: 0.0096 PINTE(s)/Unit Total : 0.0096 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

Date: Mercredi, 2007-02-28 15:16:46
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD BODY
Numéro Job: 41093 **Numéro Article:** DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
55.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot.: 1-6032-1

56.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 2% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 22/03/07 Heure Début:_______ Heure Fin:_______ Sceau: DELASTEK COMPOSITES 62

57.0	LAMINAGE.	LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 55.0000Min Total Run : 0.9167Hrs
FAIRE LE LAMINAGE DES TISSUS

Retirer les pinces et les blocs de bois

Faire le laminage d'un pli de 9.7 oz 7781 S-Glass sur le contour de la pièce selon le dessin.

Laisser sécher pendant 4 heures minimum.

Date: 22/03/07 Heure Début:_______ Heure Fin:_______ Sceau: DELASTEK COMPOSITES 62 DELASTEK COMPOSITES 32

Curing Début:__________ Curing Fin:__________

58.0	FINITION 3	FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

(2) Sabler les surfaces de la pièces pour aider à l'adhésion du primer et enlever les imperfections.

(1) Percer les 8 trous des spacers afin de les déboucher.

(1) Quantité: 1 Date: 22/03/07 Sceau: DELASTEK COMPOSITES 65

(2) Quantité: 1 Date: 27-3-07 Sceau: DELASTEK COMPOSITES 61

Date: Mercredi, 2007-02-28 15:16:46
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD BODY
Numéro Job: 41093 **Numéro Article:** DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
59.0	AAC0671	Dupont Primer N° 1104S

Commentair Qty.: 0.5000 GALLON(s)/Unit Total : 0.5000 GALLON(s)
Dupont Primer N° 1104S

60.0	AAC0670	Dupont Activatior N° 7975S

Commentair Qty.: 1.0000 PINTE(s)/Unit Total : 1.0000 PINTE(s)
Dupont Activatior N° 7975S

61.0	AAC0672	Dupont Reducer N° 12375S

Commentair Qty.: 0.1250 GALLON(s)/Unit Total : 0.1250 GALLON(s)
Dupont Reducer N° 12375S

62.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

MAR 2 8 2007 DELASTEK COMPOSITE 16

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

63.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer le primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. Application de primer.

Laisser sécher 3 heures minimum.

Date: MAR 2 8 2007 Heure Début:________ Heure Fin:________ Sceau: DELASTEK COMPOSITE 16

64.0	AAC0445	Label N° D0600-141

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)
Label N° D0600-141 N° de Lot:____________

65.0	AAC0501	Résine Mia-Poxy

Commentair Qty.: 0.015 GALLON(s)/Unit Total : 0.015 GALLON(s)
Résine Mia-Poxy N° de Lot:____________

N/A

66.0	AAC0502	Durcisseur 95 Pour Résine Mia-Poxy

Commentair Qty.: 0.030 PINTE(s)/Unit Total : 0.030 PINTE(s)
Durcisseur 95 Pour Résine Mia-Poxy N° de Lot:____________

67.0	AAC0444	Surface Veil

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Surface Veil N° de Lot:____________

Date: Mercredi, 2007-02-28 15:16:46
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Nom Dessin: SPACEPOD BODY
Numéro Job: 41093
Numéro Article: DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
68.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
ASSEMBLAGE GÉNÉRALE DART

Coller le label D0600-141 sur le spacepod en plaçant un suface veil eu dessous et par dessus le label à l'aide de résine Mia Poxy selon LF. # DKC134-0019-13

Date:______ Heure débur:______ Heure fin:______ Sceau:______

N/A Jr.

# Séq.:	Machine ou Opération:	Description :
69.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.100 UNITE(s)/Unit Total : 0.100 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

N° de Lot: 1-6044-1

# Séq.:	Machine ou Opération:	Description :
70.0	AC0059	Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.078 UNITE(s)/Unit Total : 0.078 UNITE(s)
Durcisseur Polysoft #004009 Sikkens

# Séq.:	Machine ou Opération:	Description :
71.0	FINITION 3	FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu à l'aide de Sikkens

Faire un léger sablage (grit 220) de toutes les surfaces.

Date: 29-3-07 Heure Début:______ Heure Fin:______ Sceau: DELASTEK COMPOSITES 61

# Séq.:	Machine ou Opération:	Description :
72.0	AAC0671	Dupont Primer N° 1104S

Commentair Qty.: 0.2500 GALLON(s)/Unit Total : 0.2500 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5931-2

# Séq.:	Machine ou Opération:	Description :
73.0	AAC0670	Dupont Activatior N° 7975S

Commentair Qty.: 0.5000 PINTE(s)/Unit Total : 0.5000 PINTE(s)
Dupont Activatior N° 7975S N° de Lot: 1-6041-1

# Séq.:	Machine ou Opération:	Description :
74.0	AAC0672	Dupont Reducer N° 12375S

Commentair Qty.: 0.0625 GALLON(s)/Unit Total : 0.0625 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5890-2

# Séq.:	Machine ou Opération:	Description :
75.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

MAR 29 2007 DELASTEK COMPOSITE 16

Masquer le label.

Form: rprocess

Date: Mercredi, 2007-02-28 15:16:46
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41093
Nom Dessin: SPACEPOD BODY
Numéro Article: DKC134-0053

Numéro Job:

# Séq.:	Machine ou Opération:	Description :

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

76.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 90.0000Min Total Run : 1.5000Hrs

APPLICATION DE PRIMER

Appliquer deux couches de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon les instruction du manufacturier, en prenant bien soin d'attendre 10 minutes entre les deux couches.

Laisser sécher pendant un mimimum de 3 heures.

MAR 29 2007
Date:________ Heure Début:________ Heure Fin:________ Sceau: DELASTEK COMPOSITE 16

77.0	INSPECTION 3	INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

INSPECTION GÉNÉRALE

Faire l'inspection générale de la pièces selon le dessin par le département de la qualité.

Date: 2-4-07 Sceau: DELASTEK COMPOSITE QA-2 Initiales: [signature]

Emballage OT / 2 avril 07 DELASTEK 11

 Form: rprocess

Date: Monday, 4/16/2007 2:21:35 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SPACEPOD BODY LH
Job Number	: 31767A		
Estimate Number	: 12595		
P.O. Number	:	**Part Number**	: D31881M
This Issue	: 4/16/2007 **S.O. No.** :	**Drawing Number**	: D3188 REV.E
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: E
Previous Run	: 31811A	**Material**	:
Written By	:	**Due Date**	: 5/5/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.04.16		
Comment	: Est Rev:A New issue ecn882 06-11-30 EC est rev B revc dwg 07.01.11 ec est rev C revD dwg 07.03.07 ec est rev D rev E dwg 07.04.16 EC		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	D2213	Aluminum Spacer

Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)
Ship To Delastek

8 D2213 Spacer Batch:____________

2.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: ___________
Description: D3188-1M BODY
Ship: D2213 Spacers
Supplier: Delastek
Conformity Certificate and Process sheet required
Ship 2 Items from Previous steps

W/O 30024

3.0	D31881P	Spacepod Body

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Body

4.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage.Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:21:35 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: SPACEPOD BODY LH

Job Number: 31767A
Part Number: D31881M

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D3188 .Visual inspection. Check for void spot and pins.

Seq. #:	Machine Or Operation:	Description :
6.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_______

Seq. #:	Machine Or Operation:	Description :
7.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

VL 07.04.27

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED 07.04.09

GENERAL NOTES:

1) REFERENCE DIMENSIONS MATCH AIRCRAFT CONTOUR AND DOOR OPENING

2) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING

3) MATERIALS:

RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40

FIBER: 9.7 oz 7781 WEAVE "S" GLASS (9 oz SATIN)
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
18 oz ROVING "E" GLASS (18 oz CLOTH)
OWENS CORNING MILLED FIBERS, "E" GLASS
3M K20 GLASS BUBBLES

FOAM: A500 CORE CELL
OR DIVINYCELL
OR AIREX
OR KLEGECELL
FILL VOIDS IN FOAM WITH PASTE MADE FROM MILLED FIBERS & RESIN

4) MOLD SCHEDULE:

PART	LAYUP	TRIM AND DRILL
D3188-1M/-1/-5	DT8003	DT8501
D3188-2M/-2/-6	DT8004	DT8502
D3188-3M/-3/-7	DT8500	DT8501

5) APPLY ANTI-SKID PAINT TO TOP SURFACE OF PODS PER QSI 005 4.4

6) FINISH: INSIDE/OUTSIDE WITH GREY DUPONT HIGHBUILD PRIMER 1144-S

7) ALL DIMENSIONS ARE IN INCHES

8) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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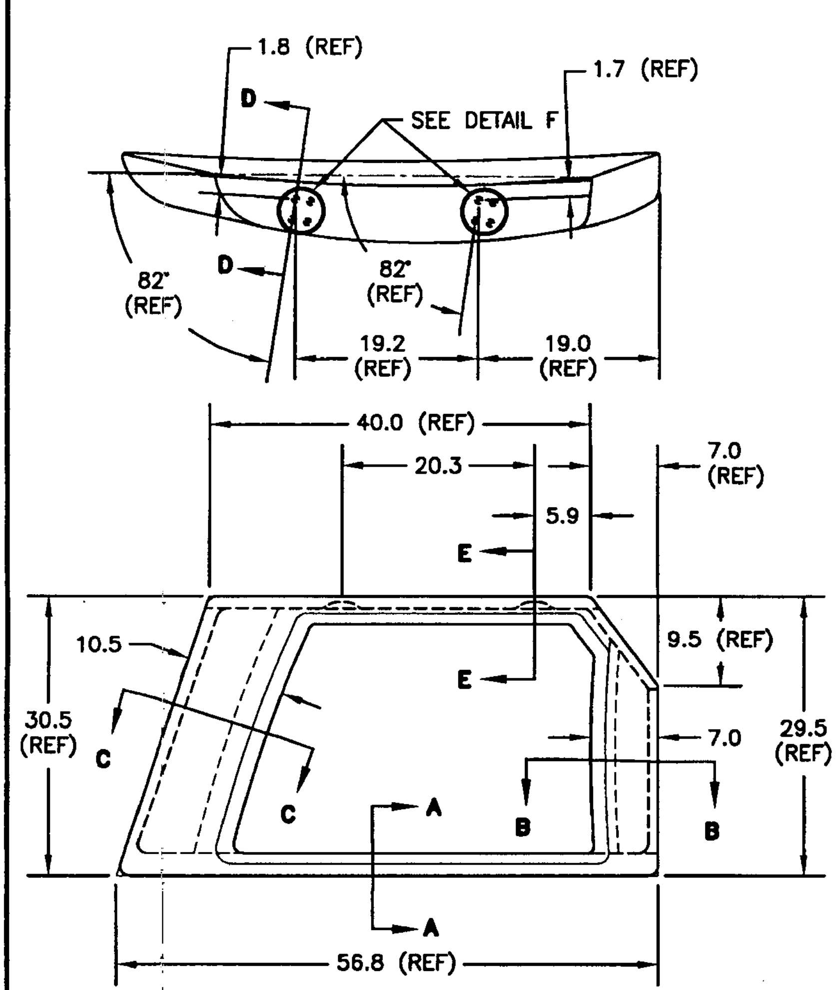
DART

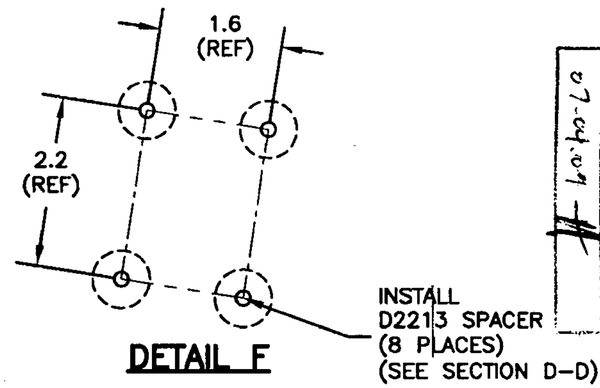
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	DRAWN BY	DRAWING NO.	REV.
JB	CB	D3188	E
CHECKED	APPROVED	TITLE	SHEET 1 OF 11
DATE 07.04.02		SPACEPOD BODY	SCALE NTS

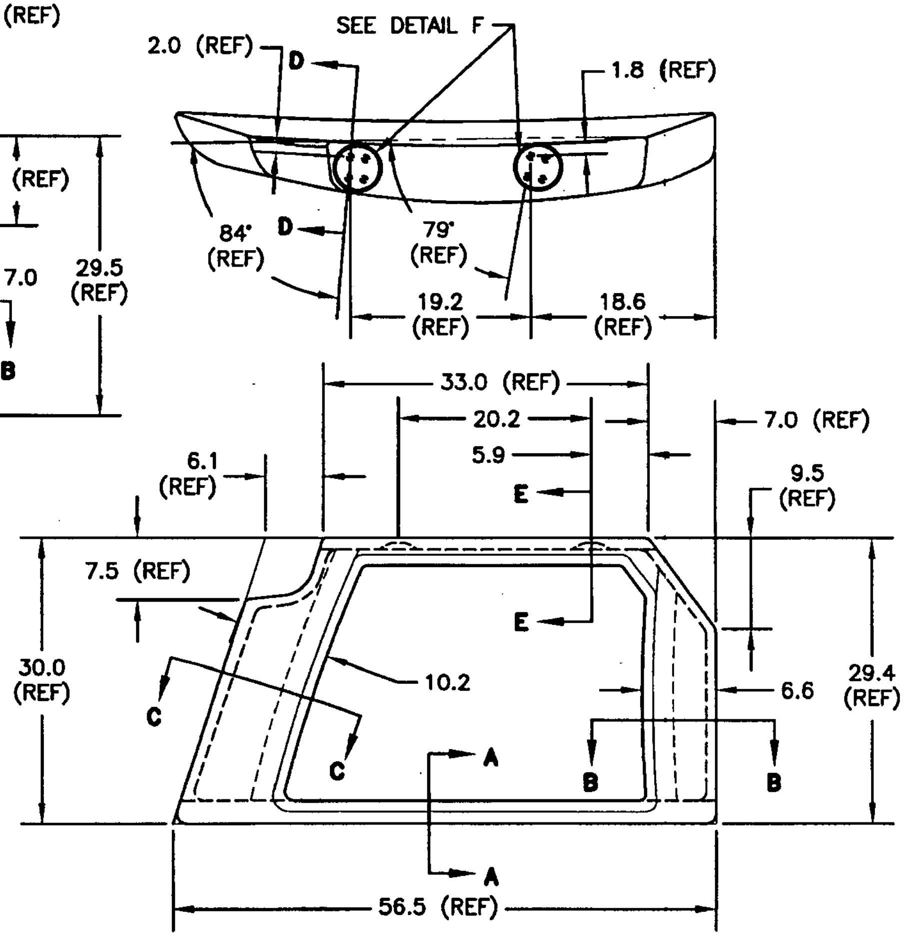
REV	DATE	DESCRIPTION
A	03.04.03	NEW ISSUE
B	06.10.06	UPDATED DWG TO MATCH PRODUCT ADDED D3188-1M/-2M/-3M/-5/-6/-7
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS
E	07.04.02	ADD HYSOL/FIBER OPTION ON SHEET 11



D3188–1M SPACEPOD BODY



DETAIL F



D3188–3M SPACEPOD BODY

D3186–1M/–3M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8003/DT8500 AND DT8501.
2) SEE SHEET #4 FOR SECTION VIEWS.

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DATE	07.04.02
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	D3188
REV.	E
SHEET	2 OF 11
TITLE	SPACEPOD BODY
SCALE	NTS

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
JB	CB	
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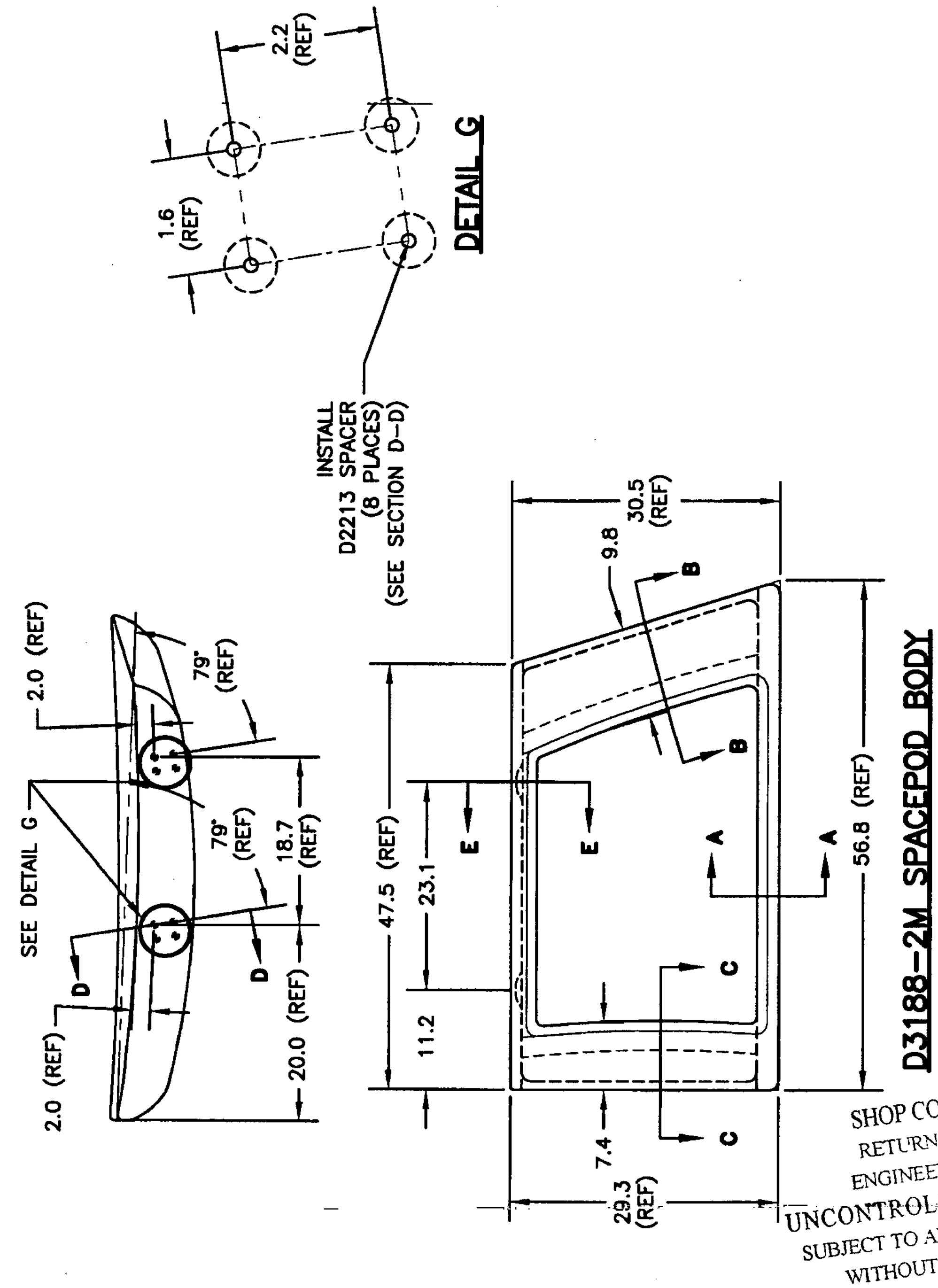
LE	[signature]	
DATE		TITLE — SCALE
07.04.02		SPACEPOD BODY — NTS

DART

RELEASED 07.04.09 [signature]



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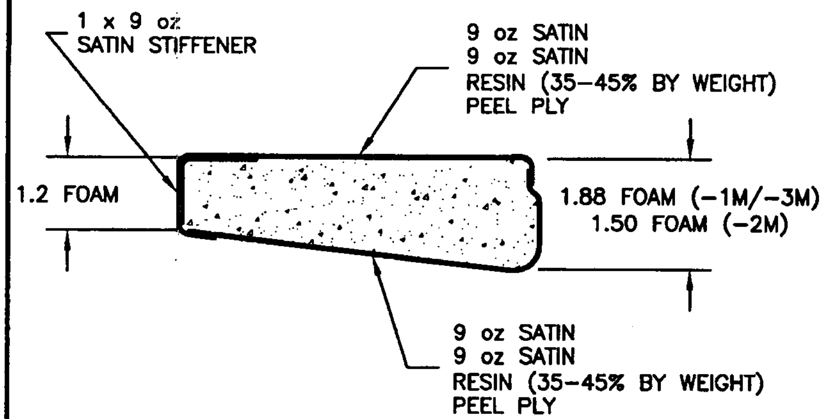
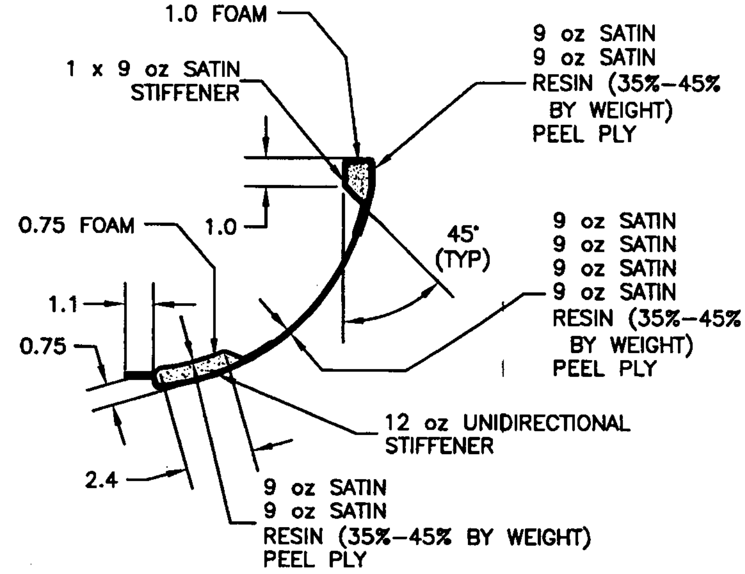
WORK ORDER NO. 31767 A

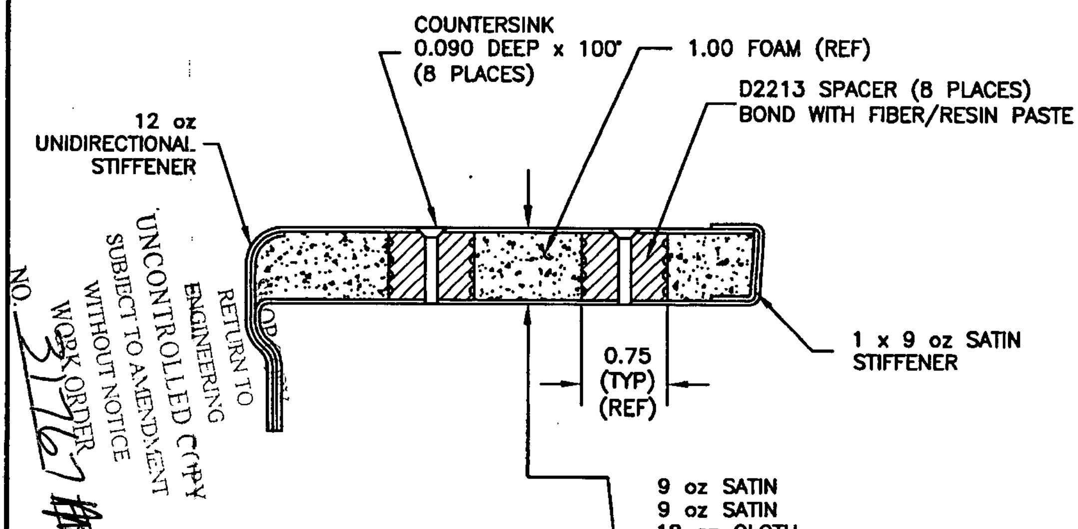
D3186-2M NOTES:
1) REFERENCE DIMENSIONS ARE FROM DT8004 AND DT8502.
2) SEE SHEET #4 FOR SECTION VIEWS.



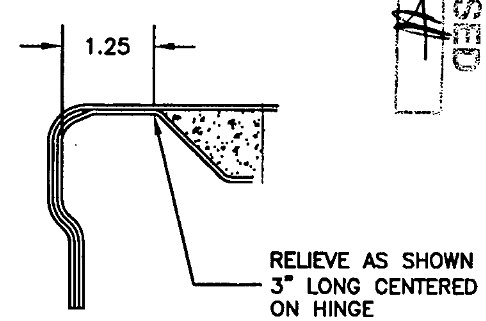
SECTION A–A
(TYPICAL FLOOR SECTION)



SECTION B–B
(SECTION C–C OPPOSITE)



SECTION D–D
(TYPICAL ROOF SECTION IS
SIMILAR BUT WITHOUT INSERTS)



SECTION E–E
(2 PLACES PER POD)

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WORK ORDER
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DRAWING NO. D3188 — REV. E
TITLE: SPACEPOD BODY
SHEET 4 OF 11
SCALE: NTS

DART

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DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

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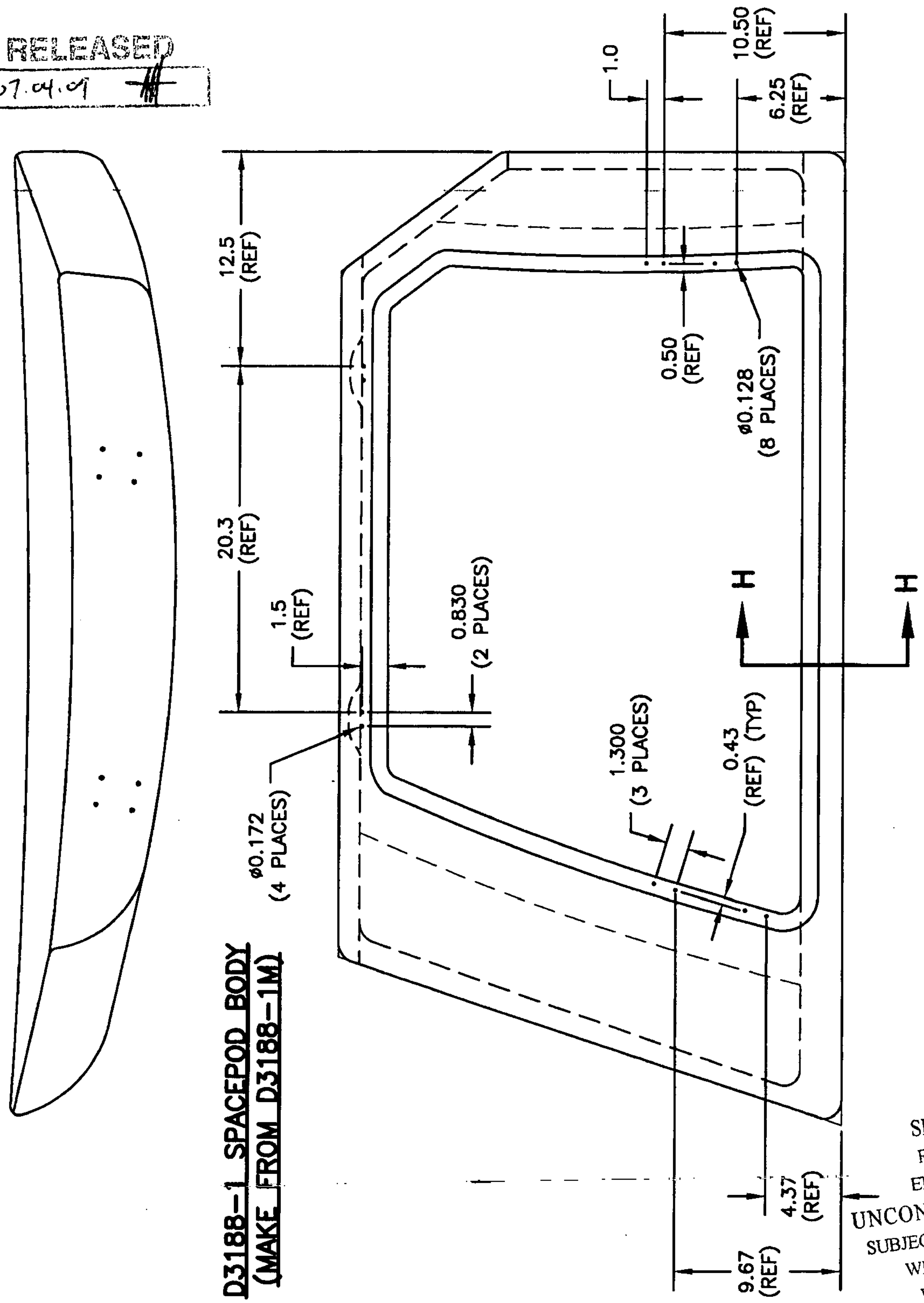

NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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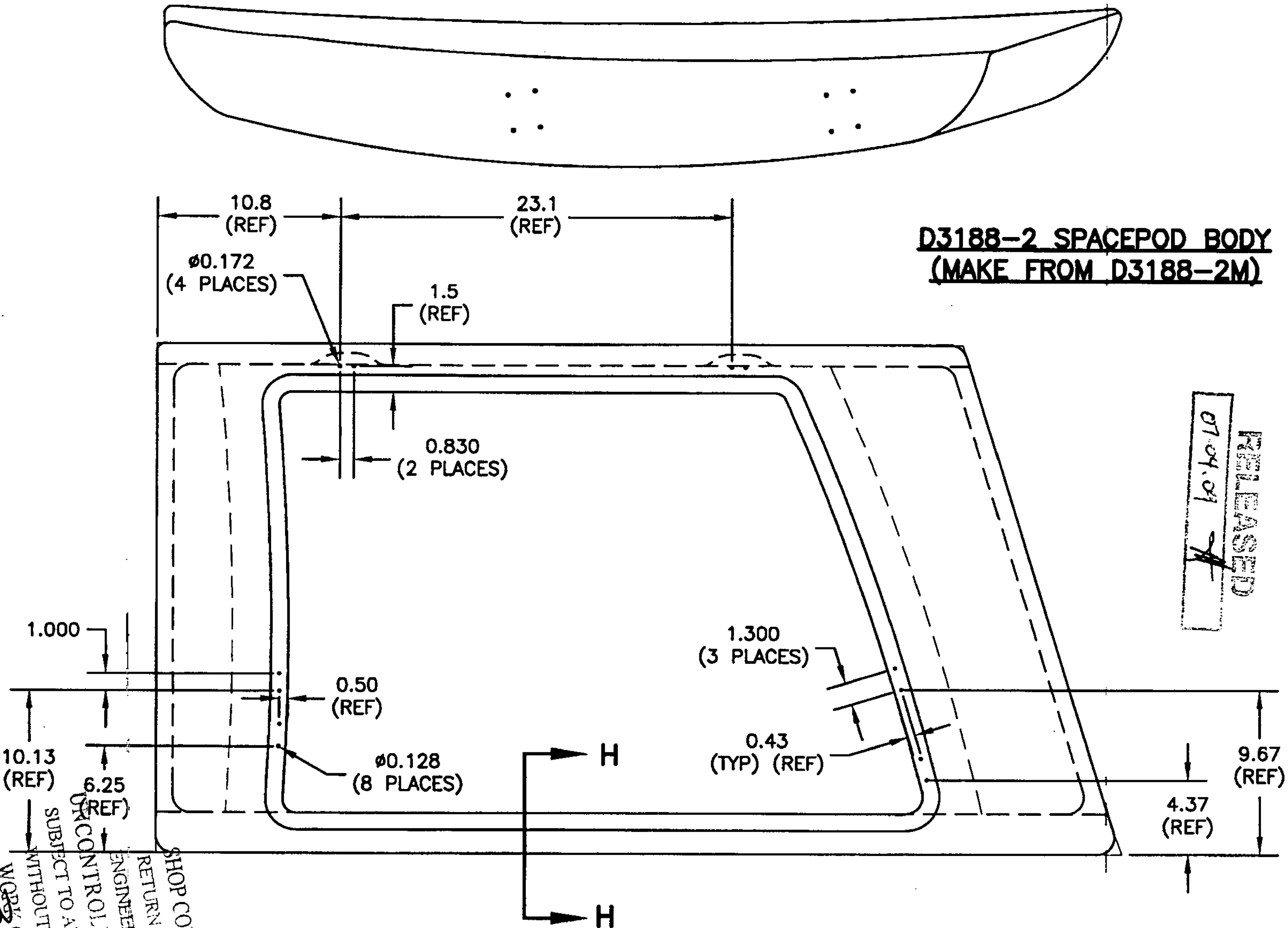
D3188-2 SPACEPOD BODY (MAKE FROM D3188-2M)



NOTES:

1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-2 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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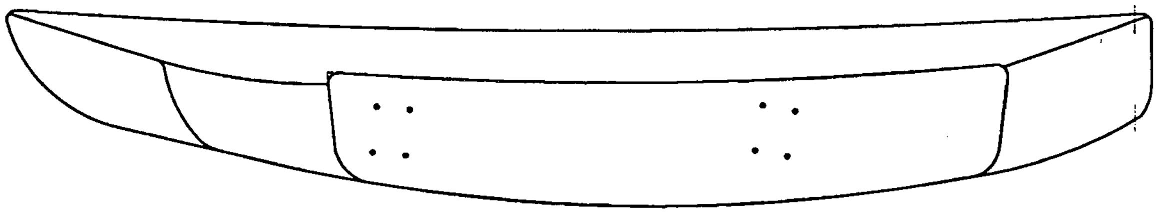
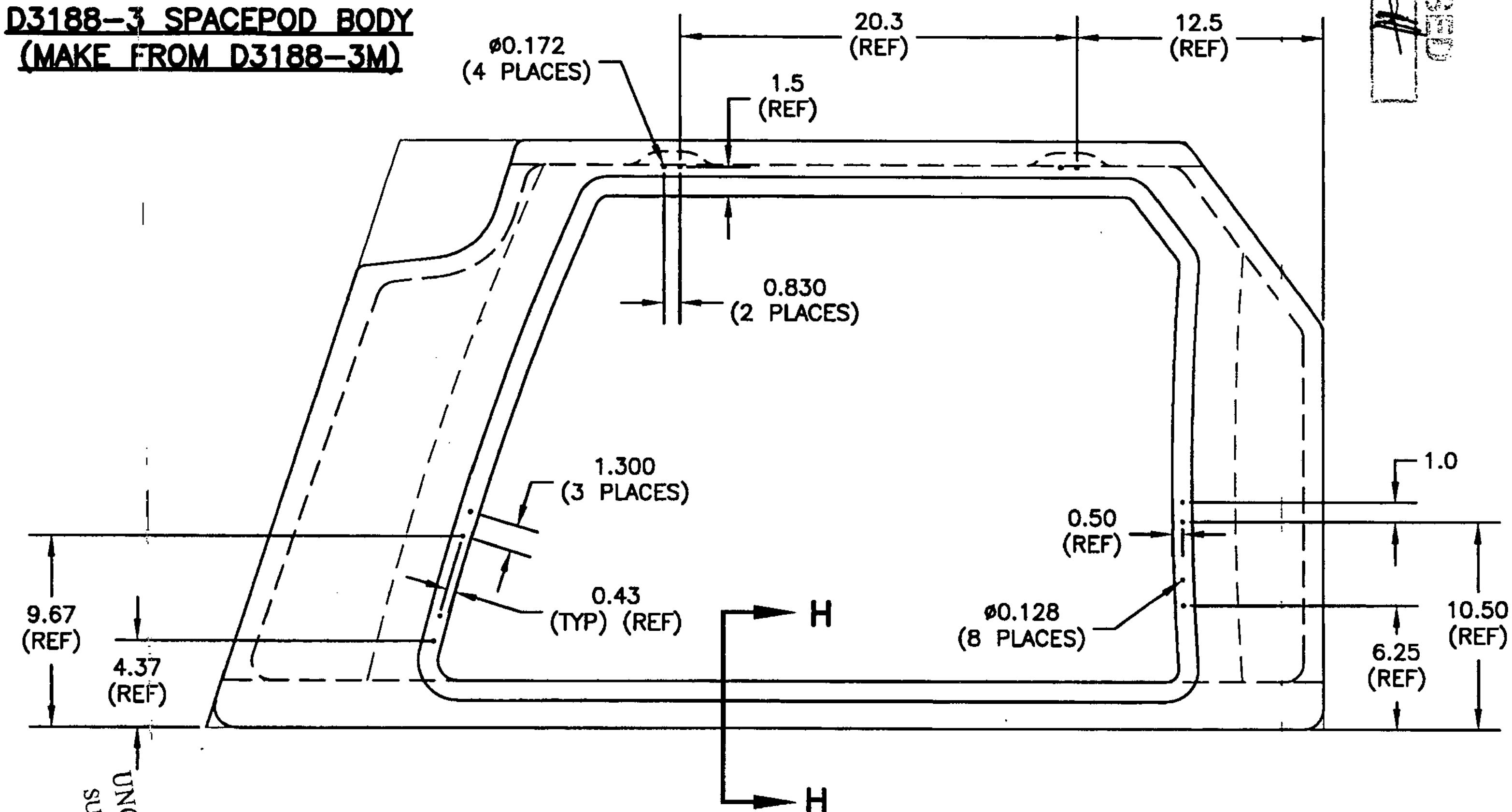
DATE 07.04.02		TITLE SPACEPOD BODY — SCALE NTS



D3188-3 SPACEPOD BODY
(MAKE FROM D3188-3M)



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-1 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEW

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DATE 07.04.02		TITLE SPACEPOD BODY — SCALE NTS

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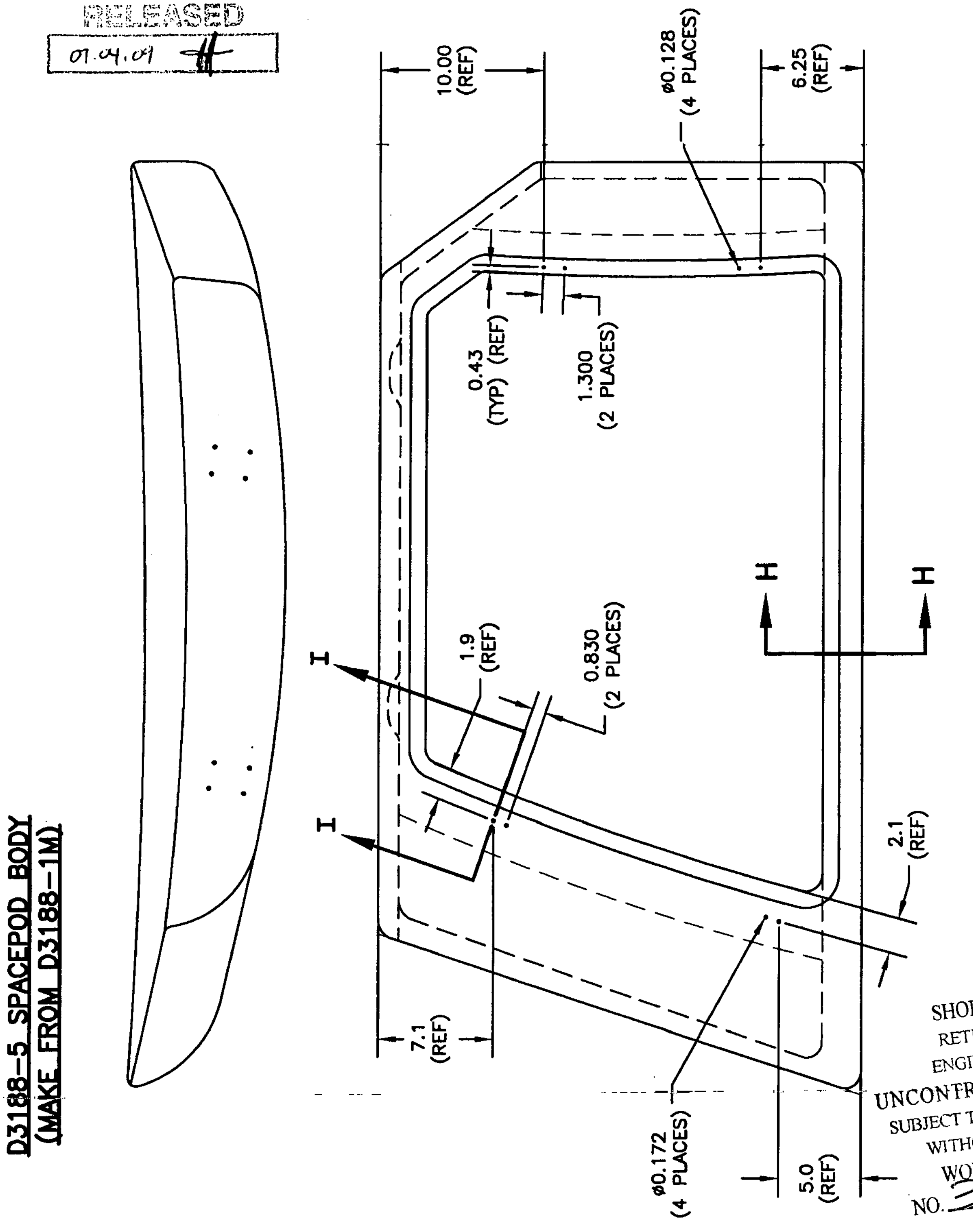
LE	[signature]	D3188	SHEET 8 OF 11
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS

DART

RELEASED 07.04.09



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
JB	CB	HAWKESBURY, ONTARIO, CANADA
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LE	[signature]	
DATE		TITLE — SCALE
07.04.02		SPACEPOD BODY — NTS

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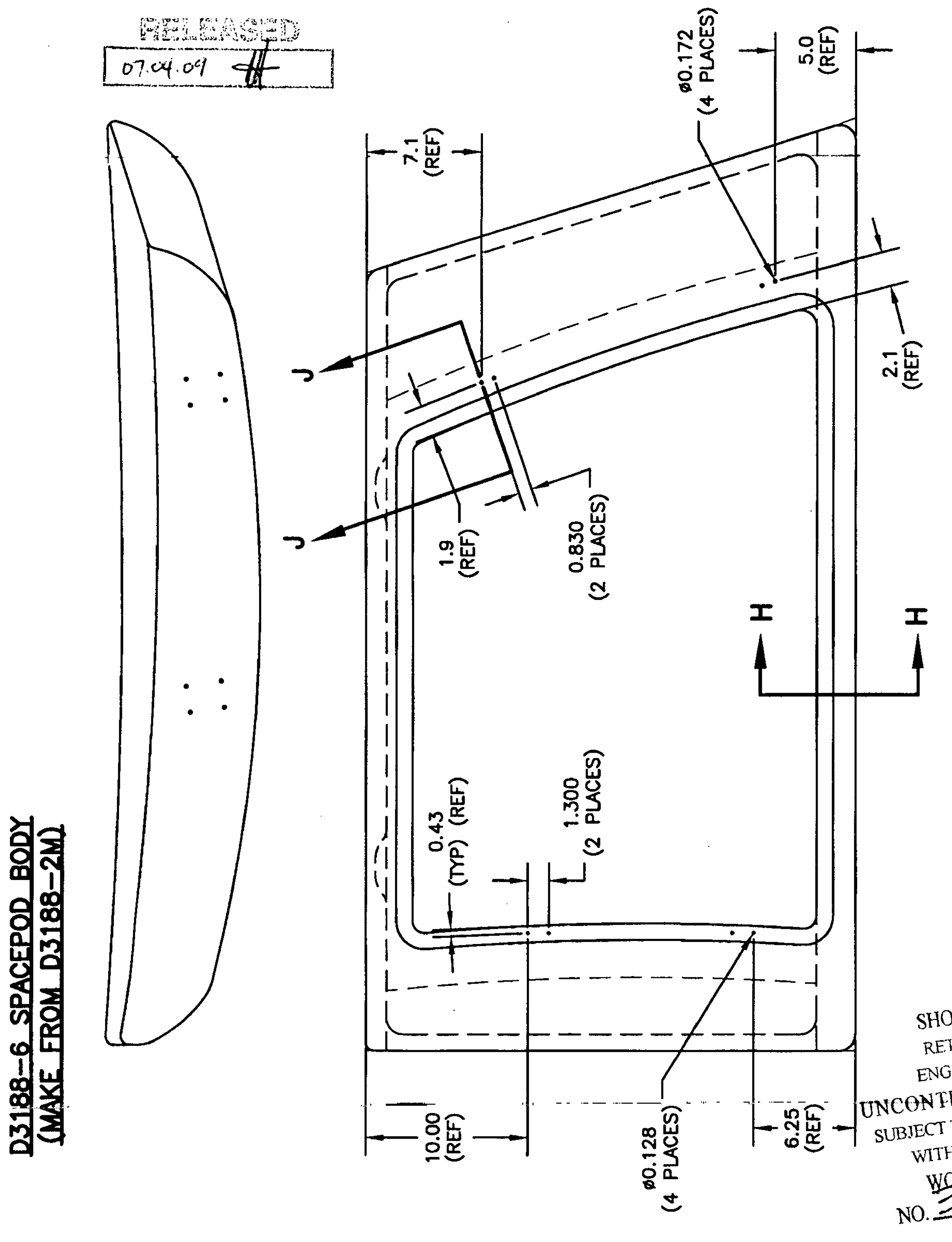
07.04.09



NOTES:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-4 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

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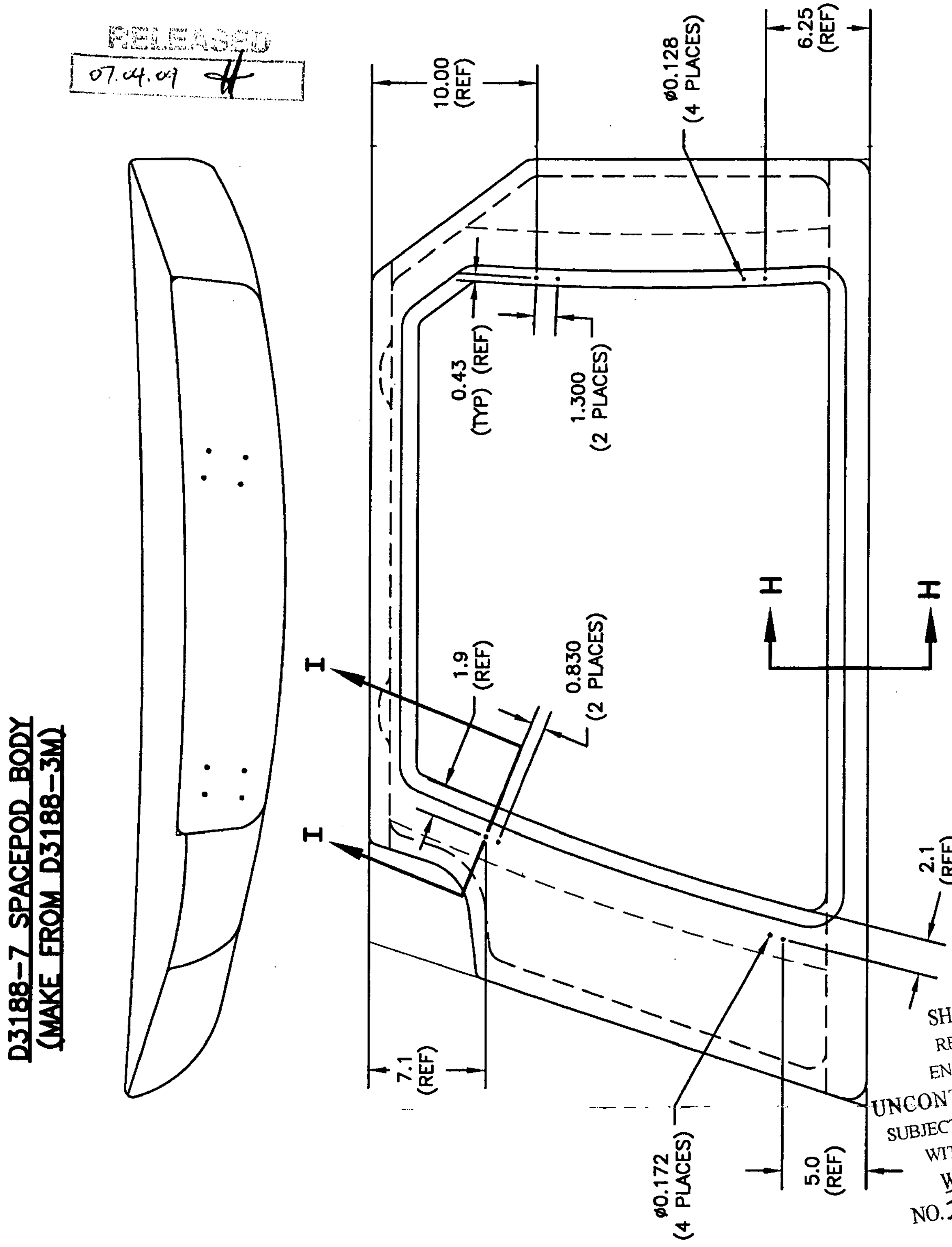
DATE 07.04.02		TITLE SPACEPOD BODY	SCALE NTS

RELEASED 07.04.09

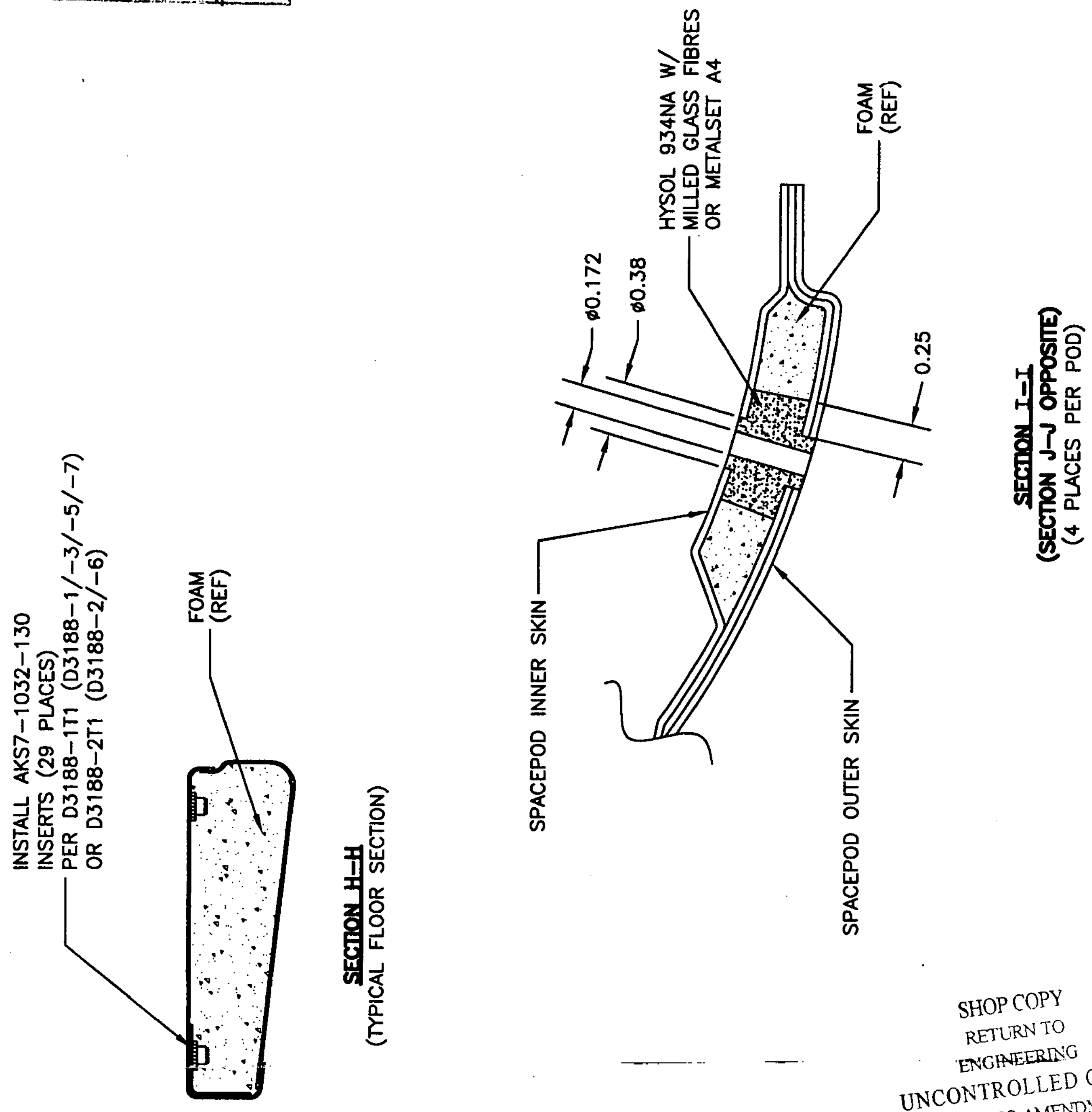


NOTE:
1) REFERENCE DIMENSIONS REPRESENT HOLES WHICH ARE TRANSFER DRILLED FROM D3186-3 DOOR DURING ASSEMBLY
2) SEE SHEET #11 FOR SECTION VIEWS

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	C.B		
CHECKED	APPROVED	DRAWING NO.	REV. E
LE	[signature]	D3188	SHEET 11 OF 11
DATE		TITLE	SCALE
07.04.02		SPACEPOD BODY	NTS

RELEASED 07.04.09



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A
WORK ORDER NO. 31767

Dart Aerospace Ltd.

Date: Wednesday, 12/20/2006 1:44:32 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SPACEPOD DOOR LH
Job Number	: 30014		
Estimate Number	: 12598		
P.O. Number	: N/A	**Part Number**	: D31861M
This Issue	: 12/20/2006 **S.O. No.** : N/A	**Drawing Number**	: D3186 REV ~~B~~ C LE 07.01.18
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : PURCHASED PARTS	**Drawing Revision**	: ~~B~~ C LE 07.01.18
Previous Run	: 30013	**Material**	: N/A
Written By	:	**Due Date**	: 1/30/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 061220		
Comment	: Est Rev:A New Issue 06-12-04 ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: 2767 CL 06/12/21
Description: D3186-1M Door
Supplier: Delastek
Conformity Certificate and Process sheet required

Seq. #:	Machine Or Operation:	Description :
2.0	D31861P	Spacepod Door

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Door

Seq. #:	Machine Or Operation:	Description :
3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage.Ensure a copy of certification of conformity and process sheet from Delastek is attached. 07/04/10

Seq. #:	Machine Or Operation:	Description :
4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins. 07/04/12

Seq. #:	Machine Or Operation:	Description :
5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: GA 07/04/12

 Form: rprocess

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______ **PAR #:** ______ **Fault Category:** ______ **NCR:** Yes / No (circled) **DQA:** [signature] **Date:** 07/04/07

QA: N/C Closed: ______ **Date:** ______

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 30014

Part Number: D31861M

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

07/04/27

Job Completion

07/04/27

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

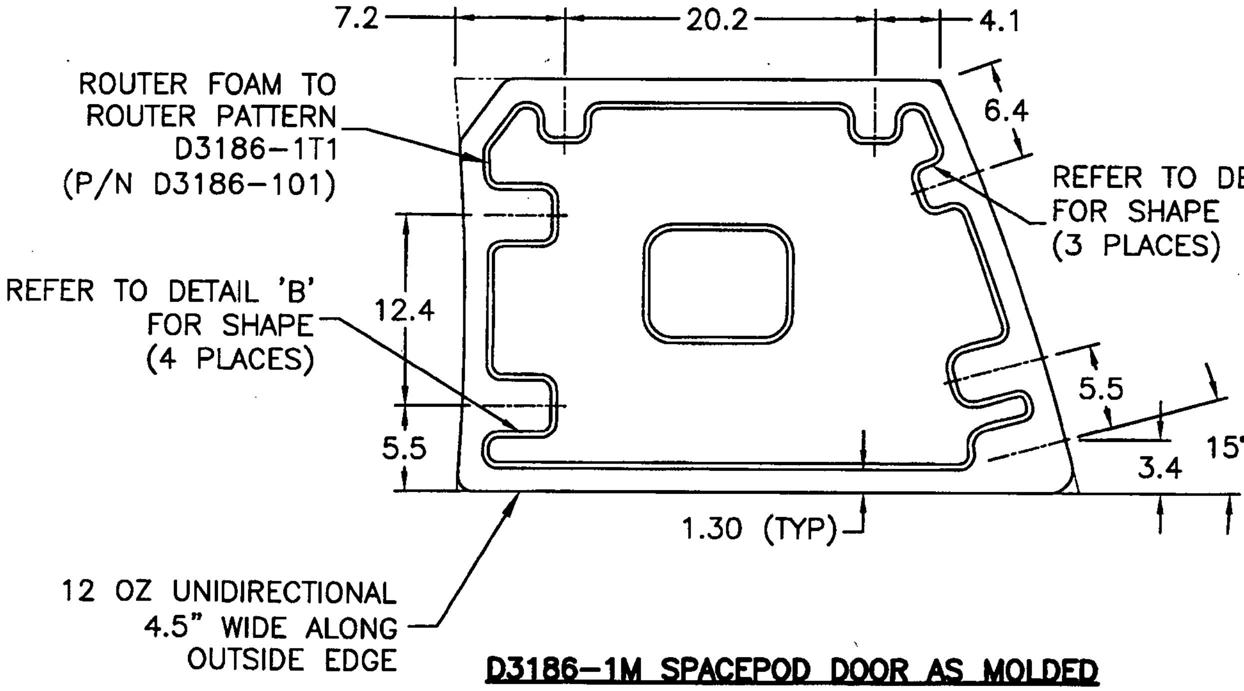
NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED	DRAWING NO. D3186 REV. C SHEET 1 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR SCALE NTS

A	03.03.27	NEW ISSUE
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED
C	06.12.13	REMOVED D0600-XXX LABELS

MAIN LAYUP
9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY



D3186-1M SPACEPOD DOOR AS MOLDED

RELEASED 06.12.22

NOTES:
1) USE MOLD DT8005 FOR DOOR LAYUP
2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
5) LAMINATE PER DART QSI 006 4.0
6) LAMINATION SCHEDULE PER THIS DRAWING
7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
8) ALL DIMENSIONS ARE IN INCHES
9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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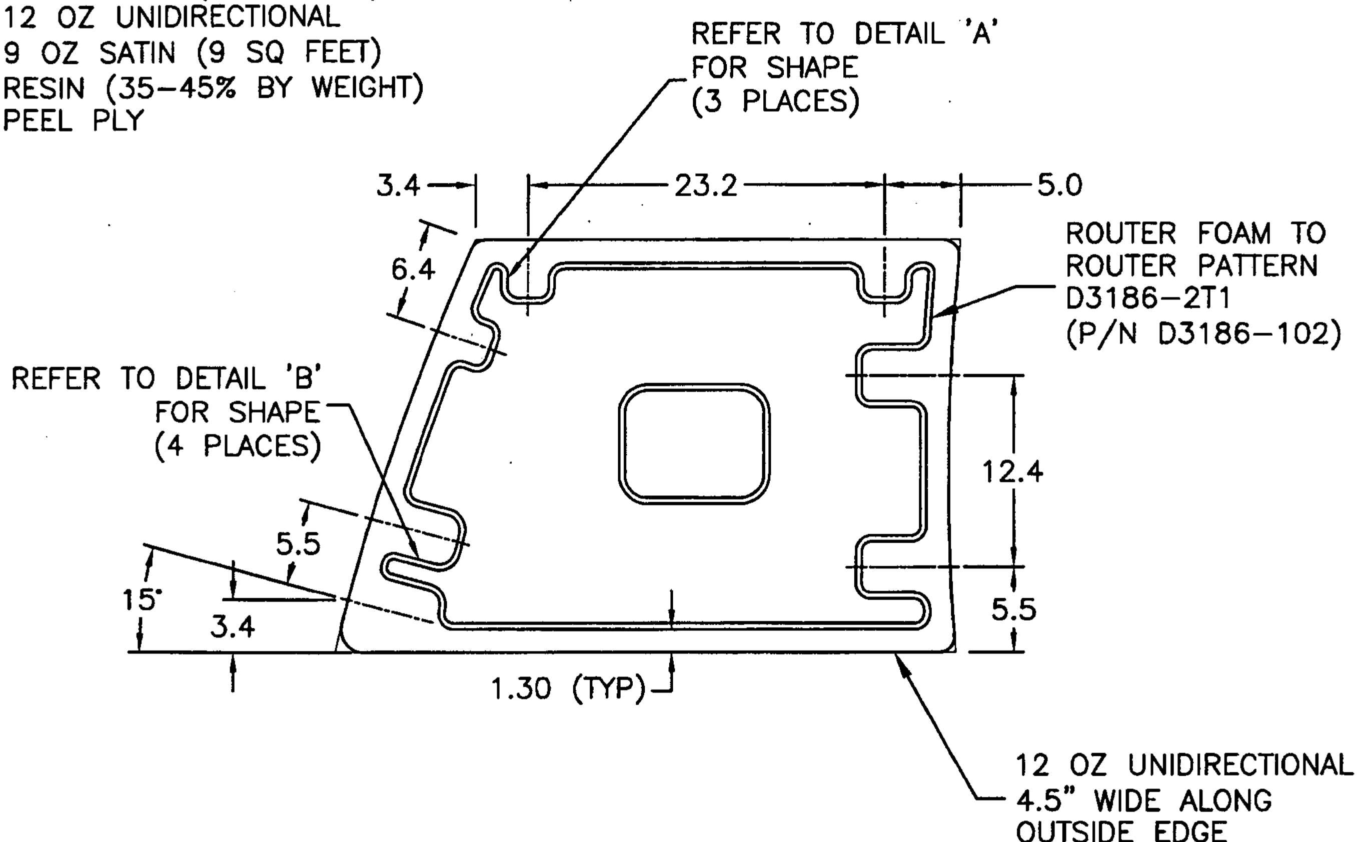
WORK ORDER NO. 30014

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
DS	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3186 — REV. C — SHEET 2 OF 5
PH	[illegible]	
DATE		TITLE — SCALE
06.12.13		SPACEPOD DOOR — NTS

MAIN LAYUP
9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35–45% BY WEIGHT)
PEEL PLY

RELEASED 06.12.22

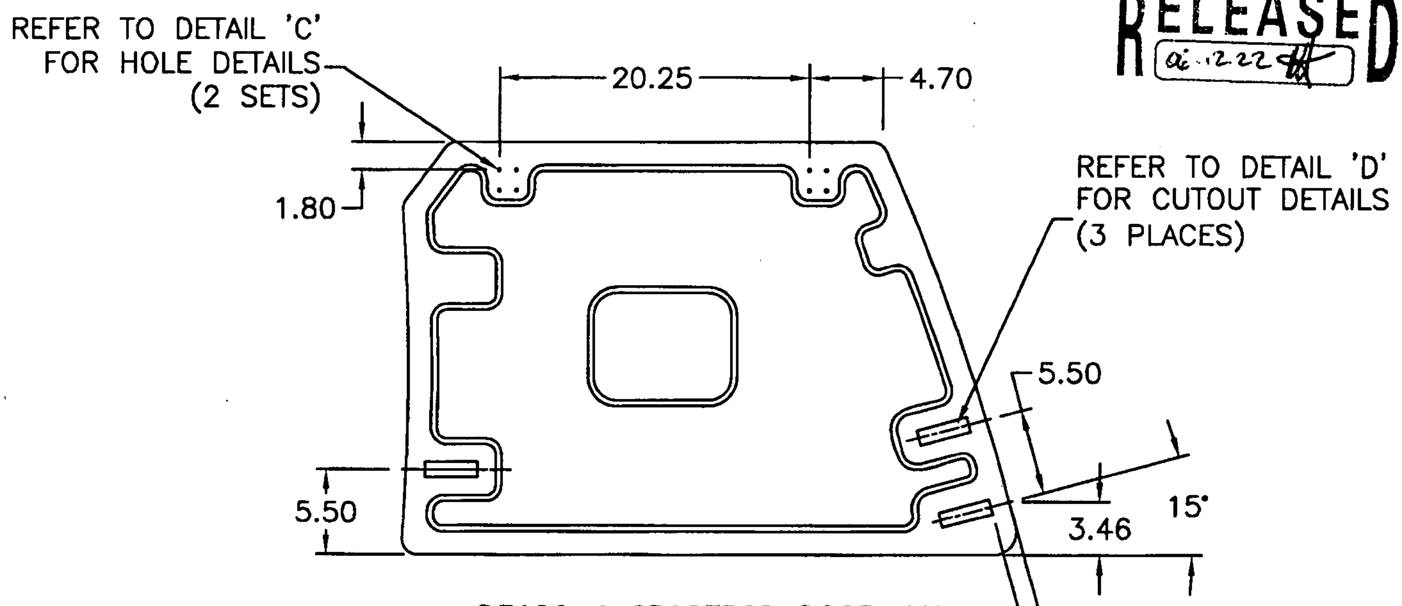


D3186–2M SPACEPOD DOOR AS MOLDED

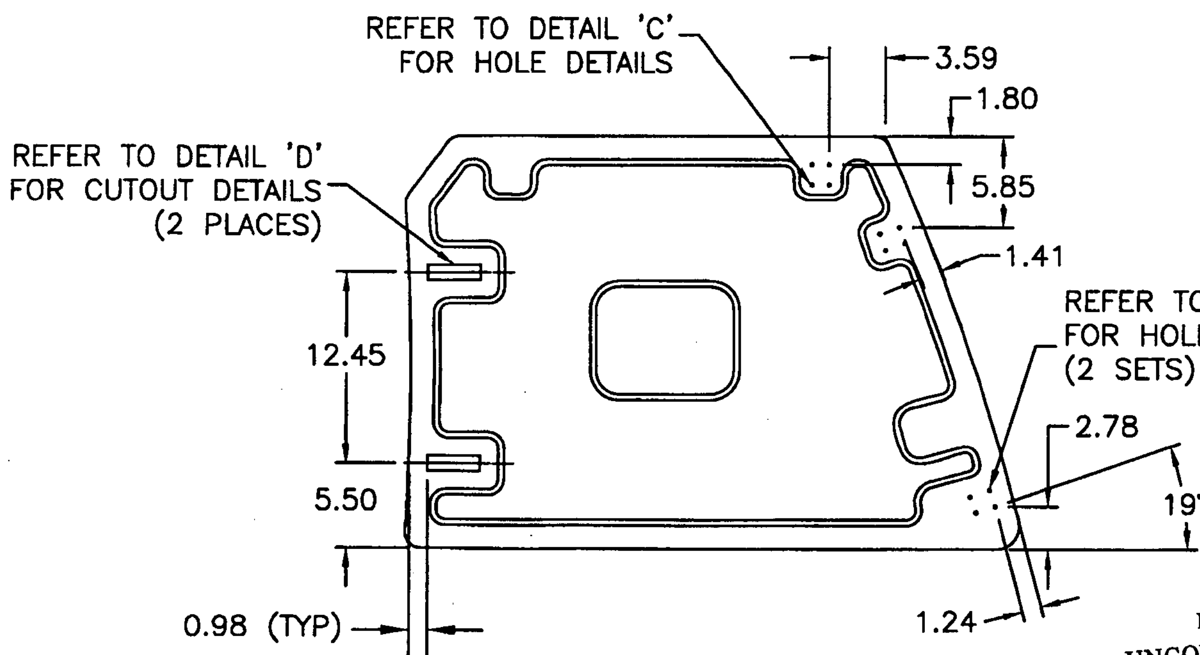
NOTES:
1) USE MOLD DT8006 FOR DOOR LAYUP
2) RESIN: EPOCAST 50–A/9816 OR DERAKANE 470–36/411/510A40
3) FOAM: 3/8", A500 CORE–CELL OR DIVINYCELL OR AIREX OR KLEGECELL
4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
   12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
5) LAMINATE PER DART QSI 006 4.0
6) LAMINATION SCHEDULE PER THIS DRAWING
7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144–S
8) ALL DIMENSIONS ARE IN INCHES
9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER
NO. 30014

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED	DRAWING NO. D3186	REV. C SHEET 3 OF 5
DATE 06.12.13		TITLE SPACEPOD DOOR	SCALE NTS



D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)



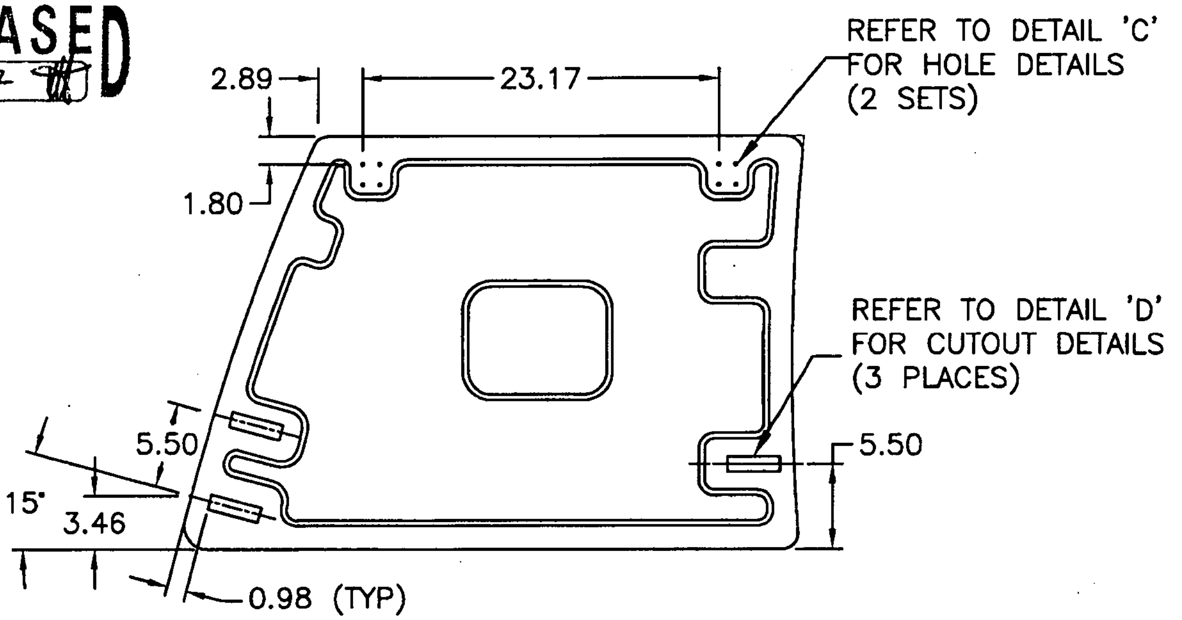
D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

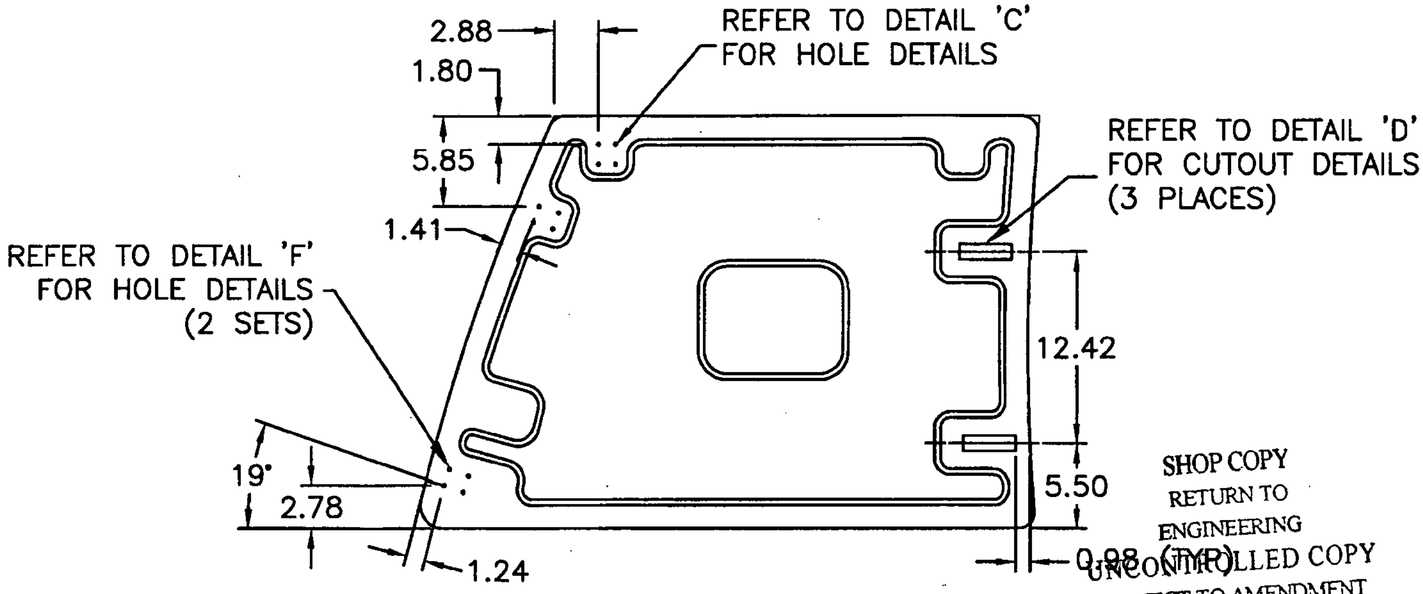
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DS	LE	
CHECKED	APPROVED	DRAWING NO. D3186 — REV. C — SHEET 4 OF 5
PH	[signature]	
DATE 06.12.13		TITLE SPACEPOD DOOR — SCALE NTS

RELEASED 06.12.22



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)



D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

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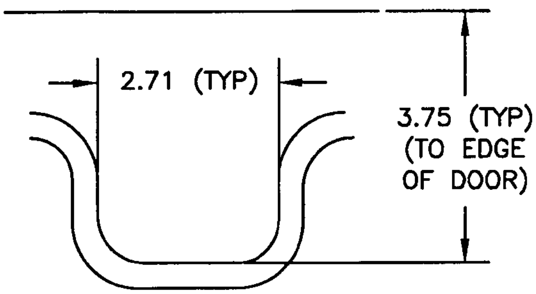
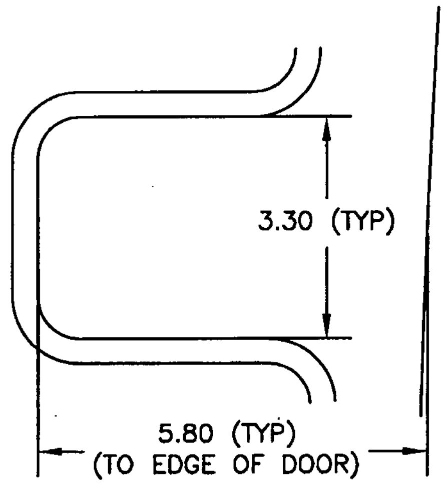
WORK ORDER
NO. 30014

NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

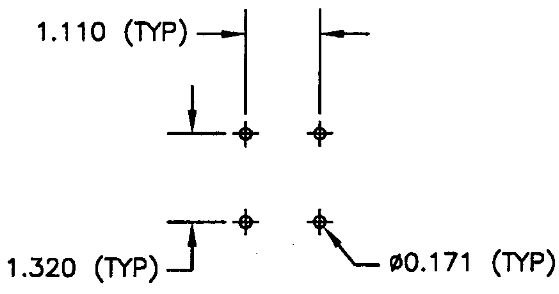
DESIGN	DRAWN BY	DART AEROSPACE LTD
DS	LE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3186 — REV. C — SHEET 5 OF 5
PH		
DATE 06.12.13		TITLE SPACEPOD DOOR — SCALE NTS



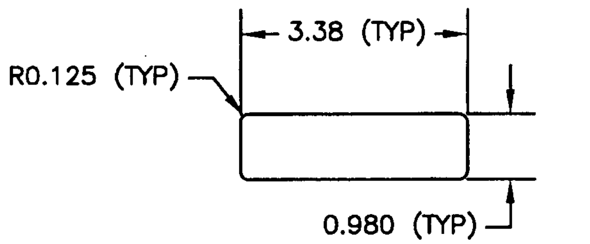
DETAIL A



DETAIL B

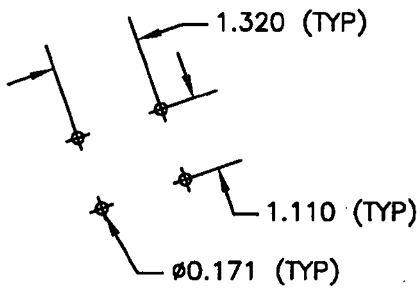


DETAIL C

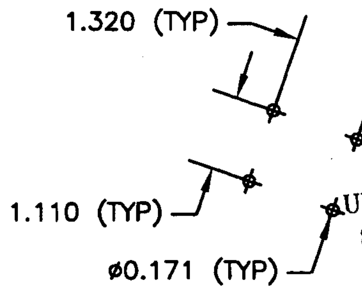


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DELASTEK COMPOSITES

DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP
CERTIFICATE OF COMPLIANCE

Invoice #	11809
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via	F.O.B.	Terms	Salesperson
EPIC EXPRESS COLLECT	Origin	Net30 days	Claude Lessard, ext. 233

Ship date	Order Date	Our PO #	Order by	Your PO #	GST/PST #
04/04/07	21/12/06	5092	C. Lavoie	PO00002767	

Order Qty	B.O. Qty	Current Ship.	Item #	Item Description	
1	0	1	DKC134-0052	D3186-1M Spacepod Door LH B30014 Dwg. Rév.: C Job: 41247	U de M : Each
1	0	1	DKC134-0053	D3188-1M Spacepod Body LH B30024 Dwg. Rév.: C Job: 41093	U de M : Each
1	0	1	DKC134-0054	D3186-2M Spacepod Door RH B30034 Dwg. Rév.: C Job: 41249	U de M : Each
1	0	1	DKC134-0055	D3188-2M Spacepod Body RH B30044 Dwg. Rév.: C Job: 41094	U de M : Each

/04/10

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Accepted by: ____________
Quality department AQ-357

DELASTEK COMPOSITES CA-2

☑ Cust. ☐ Adm. ☐ Quality ☐ Ship.

DELASTEK COMPOSITES

DELASTEK COMPOSITES Inc.
www.delastek.com

ate: Jeudi, 2007-03-22 15:15:39
tilisateur: Marc Dubé

Feuille de Procédé

:lient : DART Dart Aerospace Ltd.
luméro Job : 41247
luméro Soumission : 2584
luméro B.A. :
:ette fois : 2007-03-22 No. B.V. :
'rsht Rev. : NC
'rem. fois : - - Type :
lob précédente : 41118

Nom Dessin : SPACEPOD DOOR
Numéro Article : DKC134-0052
Numéro Dessin : D3186
Projet Numéro : DKC134
Révision dessin : C
Matériel : Fibre 7781 et Résine 411-350
Date Dûe : 2007-03-29 Qté: 1 UdM: UNITE

DELASTEK COMPOSITE 15

:crit par : ____________
/érifié & Approuvé par : ____________
:ommentaires : N° de pièce Dart Aerospace : D31861M

Process Sheet Rev.: 01 Modification générale selon informations de l'ingénierie

'roduit additionnel

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
1.0	AC0303	Frekote 44NC

Commentair Qty.: 0.020 GALLON(s)/Unit Total : 0.020 GALLON(s)
Frekote 44NC

2.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MOULE

Faire la préparation du moule N° DT 8005 à l'aide de Frekote 44NC et laisser sécher pendant 3 heures selon le QSI-006.

Date: 20/03/07 Heure Début: 8:00 Heure Fin: 11:00 Sceau: DELASTEK COMPOSITES 32

3.0	AC0409	Tissu à délaminer Release ply B

Commentair Qty.: 3.28 VERGE(s)/Unit Total : 3.28 VERGE(s)
Tissu à délaminer Release ply B

4.0	AC0407	Wrightlon 5200 Bleu P3

Commentair Qty.: 3.59 VERGE(s)/Unit Total : 3.59 VERGE(s)
Wrightlon 5200 Bleu P3

5.0	AC0408	Feutre de drainage N° Airweave N 10

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Feutre de drainage N° Airweave N 10

6.0	AC0752	Stretchlon 200 poche à vide Vert

Commentair Qty.: 3.00 VERGE(s)/Unit Total : 3.00 VERGE(s)
Stretchlon 200 poche à vide Vert

Form: rprocess

ate: Jeudi, 2007-03-22 15:15:39
tilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD DOOR
Numéro Job: 41247 **Numéro Article:** DKC134-0052

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
7.0	AAC0681	9.7 oz Weave #FG-778150-125Y Volan Finish

Commentair Qty.: 4.500 VERGE(s)/Unit Total : 4.500 VERGE(s)
9.7 oz Weave #FG-778150-125Y Volan Finish 1-6030-1

8.0	AC0098	Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 RL(s)/Unit Total : 2.2500 RL(s)
Ruban à gommer jaune #: T/AT-200Y

9.0	AAC0443	Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE CAR(s)/Unit Total : 1.00 VERGE CAR(s)
Fiberglass 12 oz Unidirectional N° de Lot: 5455

10.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
TAILLAGE DU MATÉRIEL

Tailler le matériel, selon les différents patrons de découpe :

Appliquer le Ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

À fin d'accélérer le processus de taillage, tailler les plis de 9.7 oz tous en même temps en les superposants les uns sur les autres.

Date: 16/03/07 Heure Début: 3:15 Heure Fin: 3:45 Sceau: DELASTEK COMPOSITES 32

11.0	AAC0275	Catalyst N° DDM-9

Commentair Qty.: 0.0080 PINTE(s)/Unit Total : 0.0080 PINTE(s)
Catalyst N° DDM-9 N° de Lot: 5921

12.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 KILOGRAMME(s)/Unit Total : 0.500 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-6032-1

13.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 21/03/07 Heure Début: 8:00 Heure Fin: 8:30 Sceau: DELASTEK COMPOSITES 62

Date: Jeudi, 2007-03-22 15:15:39
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41247
Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
14.0	LAMINAGE.	LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

FAIRE LE LAMINAGE DES TISSUS

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8005 et ensuite imbiber un pli de tissu 9.7oz.

Recommencer l'opération pour le deuxième pli.

Date: 21/03/07 Heure Début: 8:30 Heure Fin: 9:00 Sceau: DELASTEK COMPOSITES 32 DELASTEK COMPOSITES 62

# Séq.:	Machine ou Opération:	Description :
15.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer,
2- Film perforé P-3,
3- Feutre de drainage
4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 21/03/07 Heure Début: 9:00 Heure Fin: 9:15 Sceau: DELASTEK COMPOSITES 32 DELASTEK COMPOSITES 62

Curing Début: 9:15 Curing Fin: 4:15

# Séq.:	Machine ou Opération:	Description :
16.0	AAC0275	Catalyst N° DDM-9

Commentair Qty.: 0.0120 PINTE(s)/Unit Total : 0.0120 PINTE(s)

Catalyst N° DDM-9

N° de Lot: 5921

# Séq.:	Machine ou Opération:	Description :
17.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 KILOGRAMME(s)/Unit Total : 0.300 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Nom Dessin: SPACEPOD DOOR
Numéro Job: 41247
Numéro Article: DKC134-0052

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
18.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350 Imbiber toutes les surfaces du foam core.

Laisse sécher pendant 2 heures.

Date: 21/03/07 Heure Début: 9:15 Heure Fin: 9:30 Sceau: DELASTEK COMPOSITES 32

19.0	DKC134-0056	Foam Core N° D3186-101 (Porte D3186-1)

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-101 (Porte D3186-1) 1-5826-1

20.0	AAC0452	Polybond B46F

Commentair Qty.: 0.082 KIT(s)/Unit Total : 0.082 KIT(s)

Polybond B46F N° de Lot: 1-5865-1

21.0	ASSEMBLAGE 3	ASSEMBLAGE GÉNÉRALE DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

ASSEMBLAGE GÉNÉRALE DES PIECES

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. (Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz.)

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0056 et positionner le foam Core sur le moule selon le dessin, et selon les ligne de positionnement prévues à cet effet.

Date: 22/03/07 Heure Début: 9:30 Heure Fin: 10:00 Sceau: DELASTEK COMPOSITES 32 DELASTEK COMPOSITES 62 DELASTEK COMPOSITES 65

22.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer
2- Feutre de drainage

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD DOOR
Numéro Job: 41247 **Numéro Article:** DKC134-0052

Numéro Job:

# Séq.:	Machine ou Opération:	Description :

3- Sac à vide Stretchlon 200

Laisser sécher pendant 2 heures minimum.

Retirez le bagging avant la fin de la polymérisation (entre 1 heure et 1heure 1/2) afin d'enlever le surplus de polybond.

Date: 22/03/07 Heure Début: 10:00 Heure Fin: 10:15 Sceau: DELASTEK COMPOSITES 62, DELASTEK COMPOSITES 32, DELASTEK COMPOSITES 65

Curing Début: 10:15 Curing Fin: 12:30

23.0	AAC0275	Catalyst N° DDM-9

Commentair Qty.: 0.0400 PINTE(s)/Unit Total : 0.0400 PINTE(s)
Catalyst N° DDM-9

N° de Lot: 5921

24.0	AAC0324	Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 KILOGRAMME(s)/Unit Total : 1.000 KILOGRAMME(s)
Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-6032-1

25.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
PRÉPARATION DU MATÉRIEL

Faire la préparation de la résine selon les quantité requises, mix ration 1.5% de Catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 26/03/07 Heure Début: 3:15 Heure Fin: 3:40 Sceau: DELASTEK COMPOSITES 65

26.0	LAMINAGE.	LAMINAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs
FAIRE LE LAMINAGE DES TISSUS

Faire le liminage d'un pli de 9.7 oz.

Faire le laminage du pli de tissu de 12 oz tout le tour de la porte.

Faire le laminage du dernier pli de 9.7 oz.

Date: 26/03/07 Heure Début: 3:40 Heure Fin: 4:00 Sceau: DELASTEK COMPOSITES 65, DELASTEK COMPOSITES 62, DELASTEK COMPOSITES 32

Date: Jeudi, 2007-03-22 15:15:40
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD DOOR
Numéro Job: 41247 **Numéro Article:** DKC134-0052

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
27.0	POCHE À VIDE 1	FAIRE LA POCHE À VIDE

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

EFFECTUER LA POCHE A VIDE

Faire la poche à vide en appliquant les composantes dans l'ordre suivant:

1- Tissu à délaminer,
2- Film perforé P-3,
3- Feutre de drainage
4- Sac à vide Stretchlon 200

Laisser sécher pendant 4 heures minimum.

Date: 26/03/07 Heure Début: 4:10 Heure Fin: 4:25 Sceau: DELASTEK COMPOSITES 65, DELASTEK COMPOSITES 32, DELASTEK COMPOSITES 62

Curing Début: 4:25PM Curing Fin: 8:00AM

28.0	DÉMOULAGE 1	DÉMOULAGE PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

DÉMOULAGE DES PIECES

Démouler la pièce en faisant bien attention de ne pas abimer les coins et le " edges ".

Sabler la surface de la pièce qui était en contact avec le moule pour éliminer le fini lisse de celui-ci

Date: 27/03/07 Heure Début: 8:00 Heure Fin: 8:15 Sceau: DELASTEK COMPOSITES 65

29.0	TRIMAGE 3	TRIMAGE COMPOSITES DART

Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

TRIMAGE DE FINITION

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 27/03/07 Heure Début: 8:15 Heure Fin: 9:00 Sceau: DELASTEK COMPOSITES 65

30.0	AAC0671	Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)

Dupont Primer N° 1104S

Date: Jeudi, 2007-03-22 15:15:40
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 41247
Nom Dessin: SPACEPOD DOOR
Numéro Article: DKC134-0052

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
31.0	AAC0670	Dupont Activatior N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activatior N° 7975S

32.0	AAC0672	Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S

33.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
PRÉPARATION DU MATÉRIEL DART

MAR 28 2007 DELASTEK COMPOSITE 16

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

34.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PEINTURE / PRIMER DART

Appliquer la première couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) selon I.G. # Application du primer.

Laisser sécher pendant 3 heures.

Date: MAR 28 2007 Heure Début: ______ Heure Fin: ______ Sceau: DELASTEK COMPOSITE 16

35.0	FINITION 3	FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
FINITION PIÈCE DART

Sabler la pièce à l'aide de papier sablé grit 220 afin de corriger les inperfections et enlever le lustre du primer.

36.0	AC0058	Polysoft 1.3 kg # 003012 Sikkens

Commentair Qty.: 0.050 UNITE(s)/Unit Total : 0.050 UNITE(s)
Polysoft 1.3 kg # 003012 Sikkens

Date: Jeudi, 2007-03-22 15:15:40
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD DOOR
Numéro Job: 41247 **Numéro Article:** DKC134-0052

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
37.0	AAC0646	MASTIC POLYSOFT SIKKENS 3AR591

Commentair Qty.: 0.050 KIT(s)/Unit Total : 0.050 KIT(s)
MASTIC POLYSTOP SIKKENS 3AR591

38.0	AC0059	Durcisseur Polysoft #004009 Sikkens

Commentair Qty.: 0.039 UNITE(s)/Unit Total : 0.039 UNITE(s)
Durcisseur Polysoft #004009 Sikkens N° de Lot: 1-6044-1

39.0	FINITION 3	FINITION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs
FINITION GÉNÉRALE

Faire les réparations de finition s'il y a lieu, à l'aide de sikkens.

Date: 02-4-07 Heure Début:_______ Heure Fin:_______ Sceau: DELASTEK COMPOSITES 61

40.0	AAC0671	Dupont Primer N° 1104S

Commentair Qty.: 0.1390 GALLON(s)/Unit Total : 0.1390 GALLON(s)
Dupont Primer N° 1104S N° de Lot: 1-5931-2

41.0	AAC0670	Dupont Activatior N° 7975S

Commentair Qty.: 0.2800 PINTE(s)/Unit Total : 0.2800 PINTE(s)
Dupont Activatior N° 7975S N° de Lot: 1-6041-1

42.0	AAC0672	Dupont Reducer N° 12375S

Commentair Qty.: 0.0350 GALLON(s)/Unit Total : 0.0350 GALLON(s)
Dupont Reducer N° 12375S N° de Lot: 1-5390-2

43.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART

Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs
PRÉPARATION DU MATÉRIEL

APR 02 2007 DELASTEK COMPOSITE 16

Bien brasser les trois contenants servant à faire le mélange du primer gris N° 1104S et ensuite faire le mélange selon les instruction du fabriquant.

44.0	PEINT/ PRIMER2	PEINTURE / PRIMER DART

Commentair Setup: 0.00Hrs/ Run: 20.0000Min Total Run : 0.3333Hrs
APPLICATION DE PRIMER

Appliquer la deuxième couche de primer Dupont N° 1104S (7975S Activator, 12375S Reducer) Selon I.G. #
Application du primer

Date: APR 02 2007 Heure Début: ~~Heure Fin:~~ Sceau: DELASTEK COMPOSITE 16

Date: Jeudi, 2007-03-22 15:15:40
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd. **Nom Dessin:** SPACEPOD DOOR
Numéro Job: 41247 **Numéro Article:** DKC134-0052

Numéro Job:

# Séq.:	Machine ou Opération:	Description :
45.0	INSPECTION 3	INSPECTION PIÈCE DART

Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs
INSPECTION PIÈCE DART 1 PIECE 4-4-07

DELASTEK COMPOSITE QA-2

Emballage QT 1 4 avril 07

DELASTEK 11

Dart Aerospace Ltd.

Date: Monday, 4/16/2007 2:21:36 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SPACEPOD DOOR LH
Job Number	: 31767B		
Estimate Number	: 12635		
P.O. Number	: N/A	**Part Number**	: D31863
This Issue	: 4/16/2007 **S.O. No.** : N/A	**Drawing Number**	: D3186 REV.D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: N/A **Type** : SMALL /MED FAB	**Drawing Revision**	: D
Previous Run	: 31811B	**Material**	: N/A
Written By	:	**Due Date**	: 5/5/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.04.16		
Comment	: Est Rev:A New Issue 07-01-11 EC est rev B rev D dwg 07.03.07 ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :	
1.0	31767B01	SPACEPOD DOOR LH W/O 30014	ml 07/04/17
	Comment: Sub-Component SPACEPOD DOOR LH		
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill holes and cut out latch slots per dwg D3186 (D3186-3 detail)		ml 07/04/18
3.0	QC5	INSPECT WORK TO CURRENT STEP 07.04.18 (1)	
	Comment: INSPECT WORK TO CURRENT STEP		
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: GA		ml 07/04/19
5.0	QC21	FINAL INSPECTION/W/O RELEASE	(1)
	Comment: FINAL INSPECTION/W/O RELEASE		07/04/27

Job Completion

07.04.27

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ________ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** [illegible] **Date:** 07/04/27

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

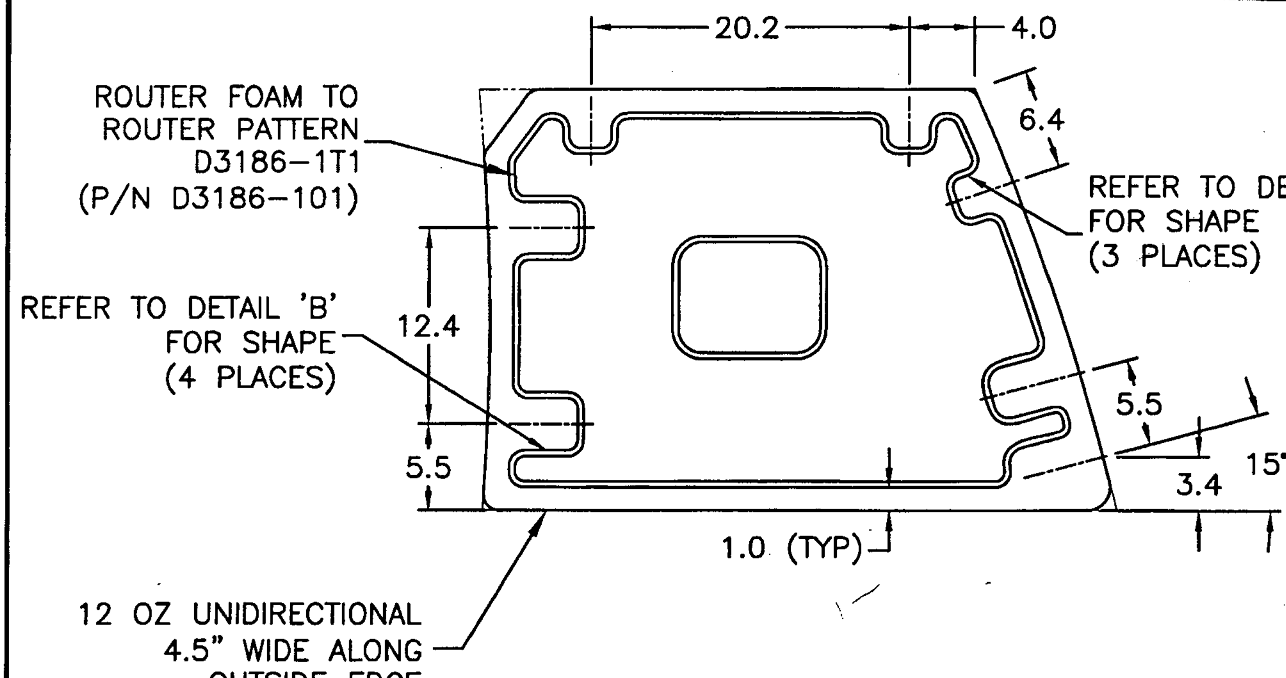
H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3186 — REV. D — SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR — SCALE NTS

REV	DATE	DESCRIPTION
A	03.03.27	NEW ISSUE
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS

MAIN LAYUP
9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED 07.02.27



D3186-1M SPACEPOD DOOR AS MOLDED

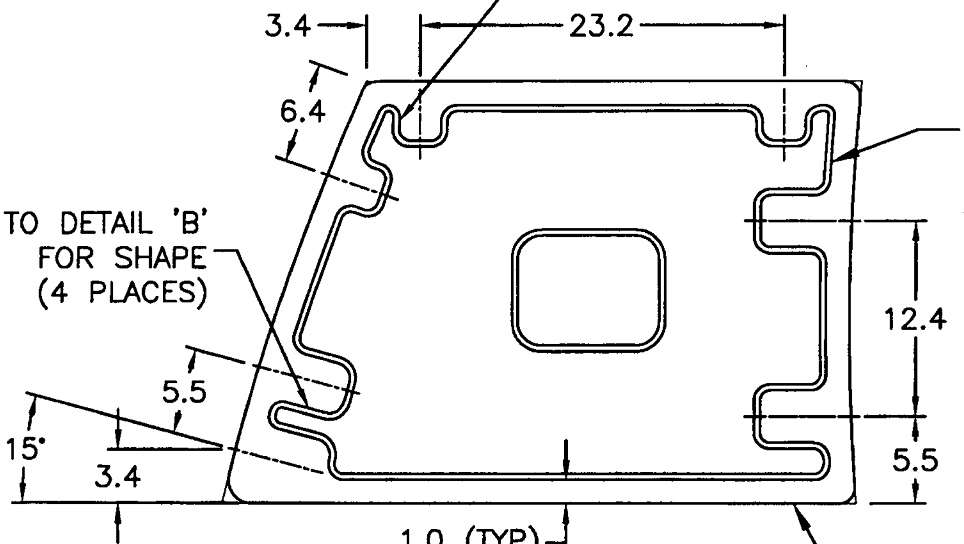
NOTES:
1) USE MOLD DT8005 FOR DOOR LAYUP
2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
   12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
5) LAMINATE PER DART QSI 006 4.0
6) LAMINATION SCHEDULE PER THIS DRAWING
7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
8) ALL DIMENSIONS ARE IN INCHES
9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DS	LE	
CHECKED	APPROVED	DRAWING NO. D3186 — REV. D — SHEET 2 OF 5
DATE		TITLE — SCALE
07.02.22		SPACEPOD DOOR — NTS

MAIN LAYUP
9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35–45% BY WEIGHT)
PEEL PLY

RELEASED
07.02.27



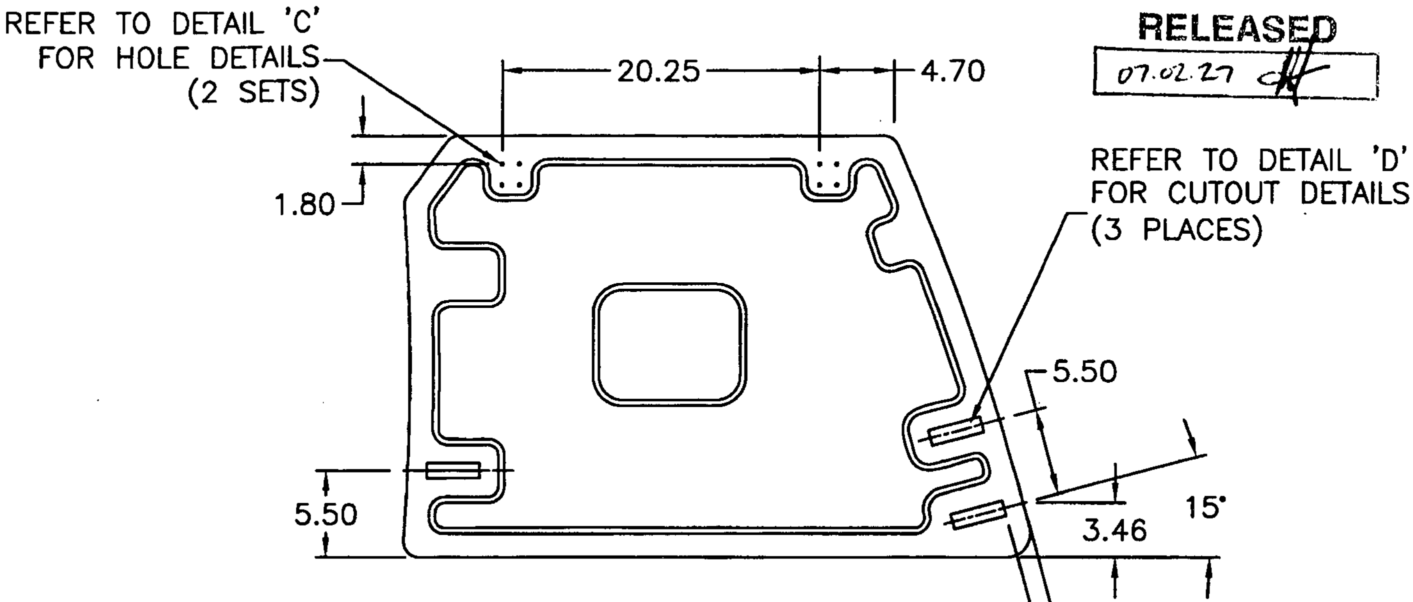
D3186–2M SPACEPOD DOOR AS MOLDED

NOTES:
1) USE MOLD DT8006 FOR DOOR LAYUP
2) RESIN: EPOCAST 50–A/9816 OR DERAKANE 470–36/411/510A40
3) FOAM: 3/8", A500 CORE–CELL OR DIVINYCELL OR AIREX OR KLEGECELL
4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
5) LAMINATE PER DART QSI 006 4.0
6) LAMINATION SCHEDULE PER THIS DRAWING
7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144–S
8) ALL DIMENSIONS ARE IN INCHES
9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

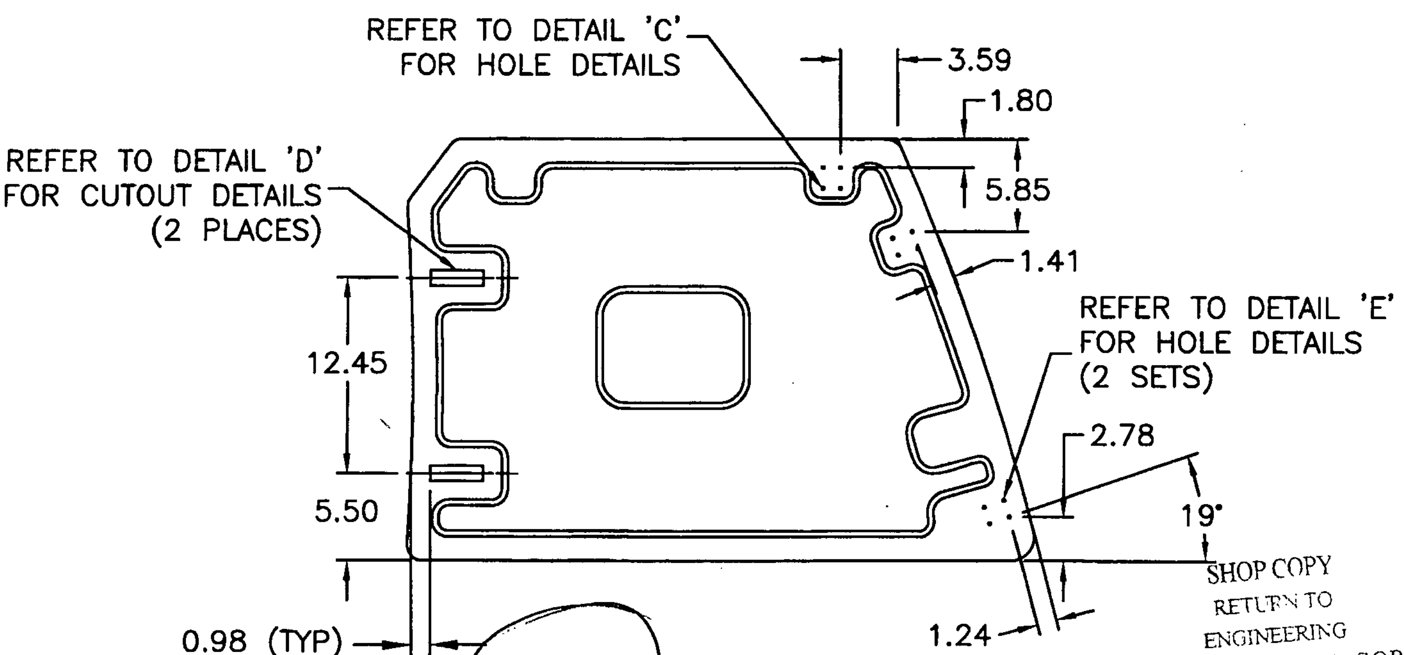
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DS	LE		
CHECKED	APPROVED	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

DART

RELEASED 07.02.27



D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)



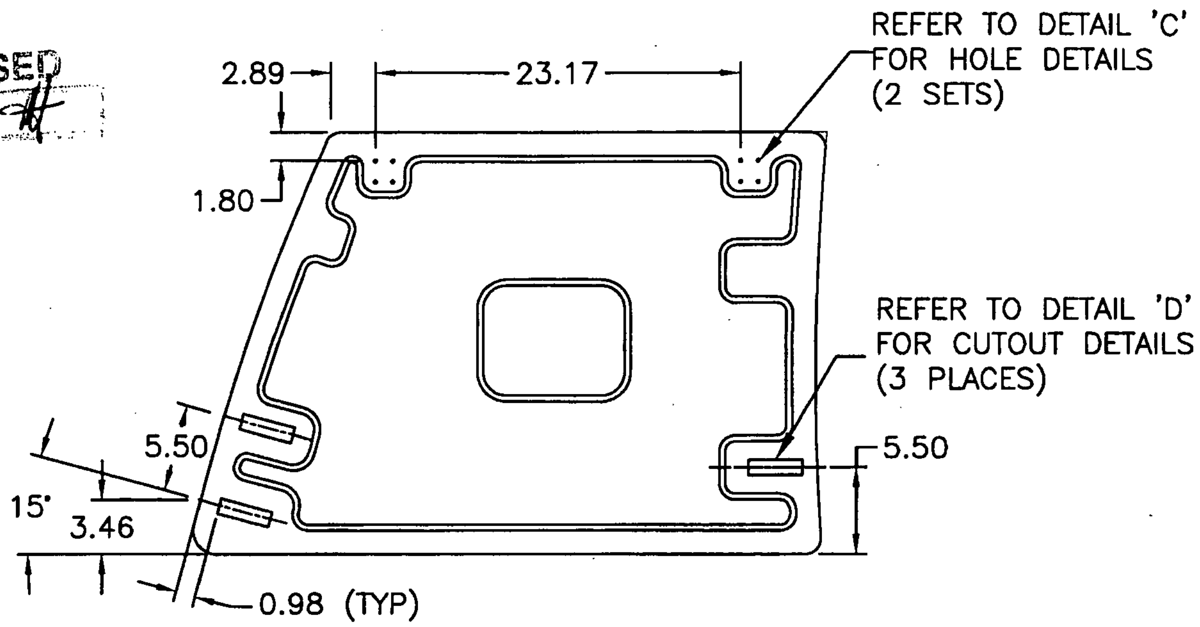
D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31767B

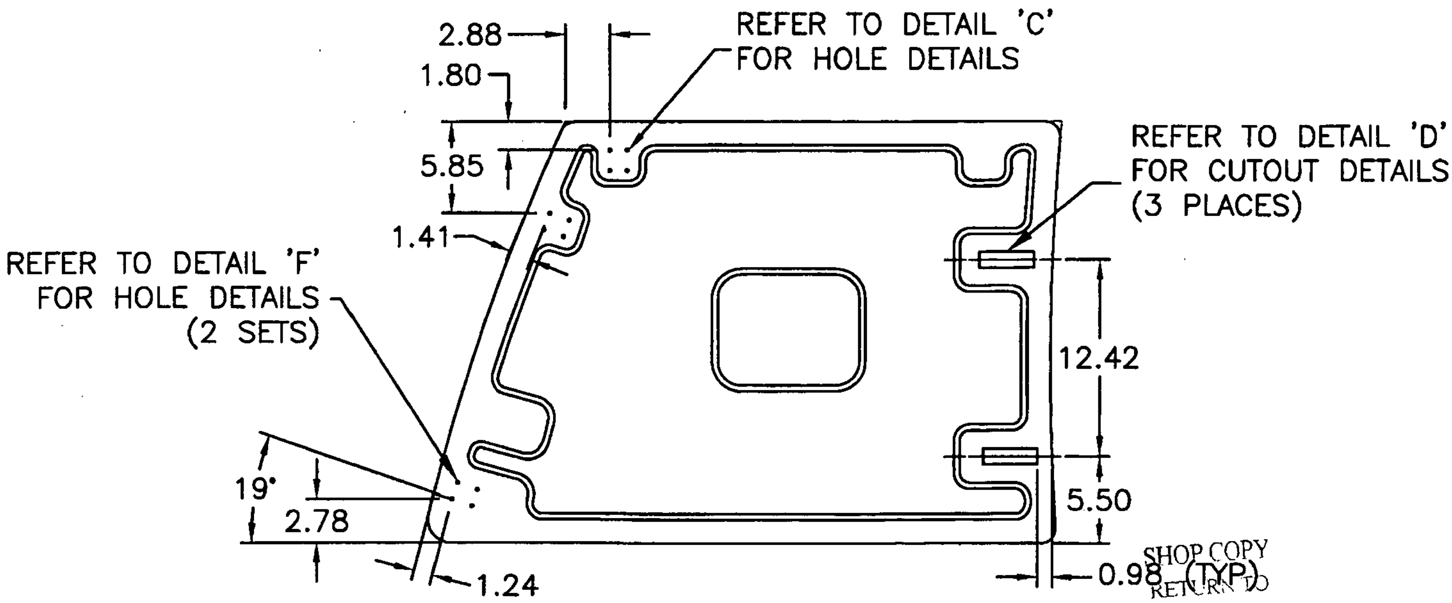
NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DS	LE		
CHECKED	APPROVED	DRAWING NO.	REV. D
		D3186	SHEET 4 OF 5
DATE		TITLE	SCALE
07.02.22		SPACEPOD DOOR	NTS



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

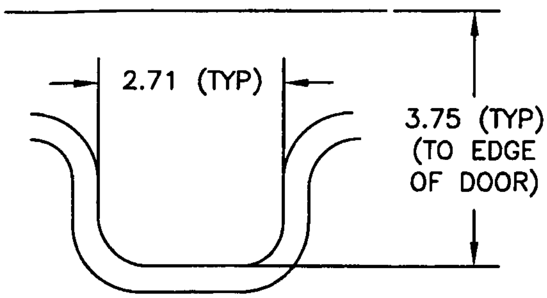


D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

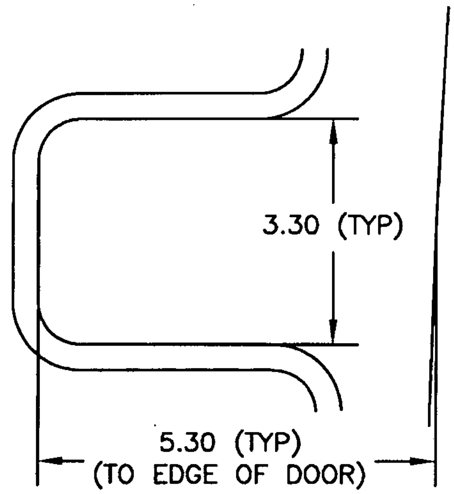
NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

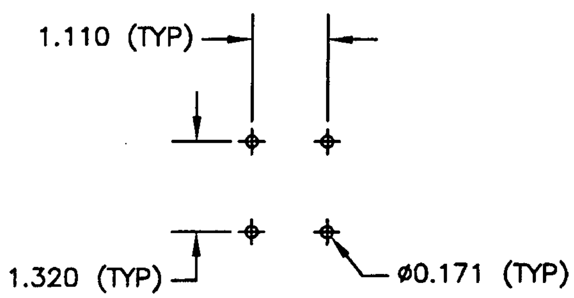


DETAIL A

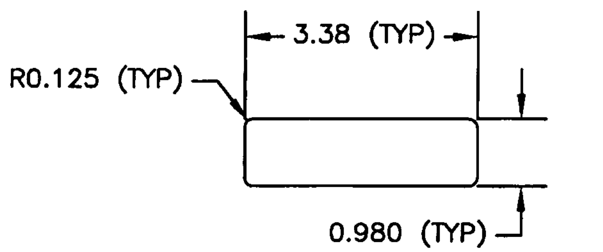


DETAIL B

RELEASED
07.02.27

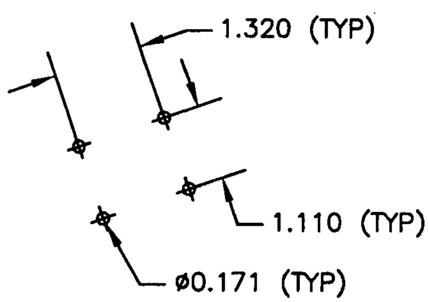


DETAIL C

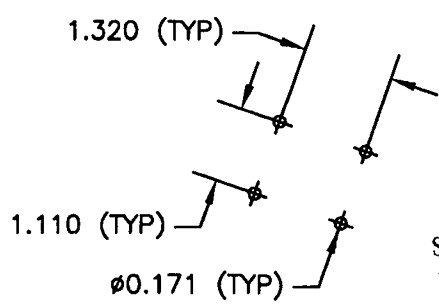


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Date: Monday, 4/16/2007 2:21:39 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: SPACEPOD DOOR LH
Job Number	: 31767B01		
Estimate Number	: 12598		
P.O. Number	:	**Part Number**	: D31861M
This Issue	: 4/16/2007 **S.O. No.** :	**Drawing Number**	: D3186 REV.D
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : SMALL /MED FAB	**Drawing Revision**	: D
Previous Run	: 31811B01	**Material**	:
Written By	:	**Due Date**	: 5/5/2007 **Qty:** 1 **Um:** Each
Checked & Approved By	: 07.04.16		
Comment	: Est Rev:A New Issue 06-12-04 ec est rev D rv D dwg 07.03.07 ec		

Additional Product

Job Number:

Seq. #:	**Machine Or Operation:**	**Description :**
1.0	PG	PURCHASING

Comment: PURCHASING
Issue P/O: ___________
Description: D3186-1M Door
Supplier: Delastek
Conformity Certificate and Process sheet required

W/O 30014

2.0	D31861P	Spacepod Door

Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Spacepod Door

3.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Receive and inspect for transit damage.Ensure a copy of certification of conformity and process sheet from Delastek is attached.

4.0	QC6	DIMENSIONAL CHECK

Comment: DIMENSIONAL CHECK
Inspect dimensions as per Dwg D3186 .Visual inspection. Check for void spot and pins. Ensure surface of doo is smooth, no dimples for drilling.

5.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_______

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: _________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/16/2007 2:21:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACEPOD DOOR LH

Job Number: 31767B01

Part Number: D31861M

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion

a 5Feb.27

Form: mprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** _______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

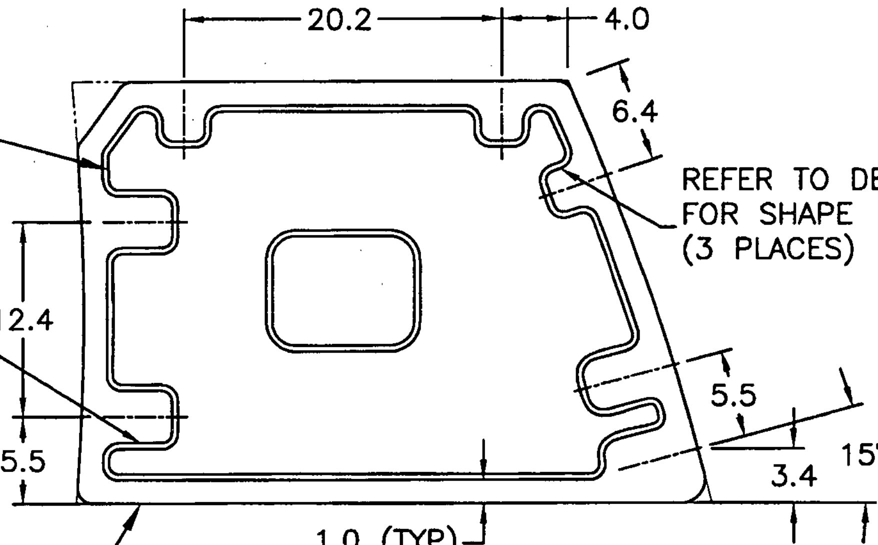
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DS	LE		
CHECKED	APPROVED	DRAWING NO. D3186	REV. D SHEET 1 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

REV	DATE	DESCRIPTION
A	03.03.27	NEW ISSUE
B	06.09.25	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M/-2M/-3/-4 ADDED
C	06.12.13	REMOVED D0600-XXX LABELS
D	07.02.22	UPDATE DIMENSIONS

MAIN LAYUP
9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35-45% BY WEIGHT)
PEEL PLY

RELEASED 07.02.27



D3186-1M SPACEPOD DOOR AS MOLDED

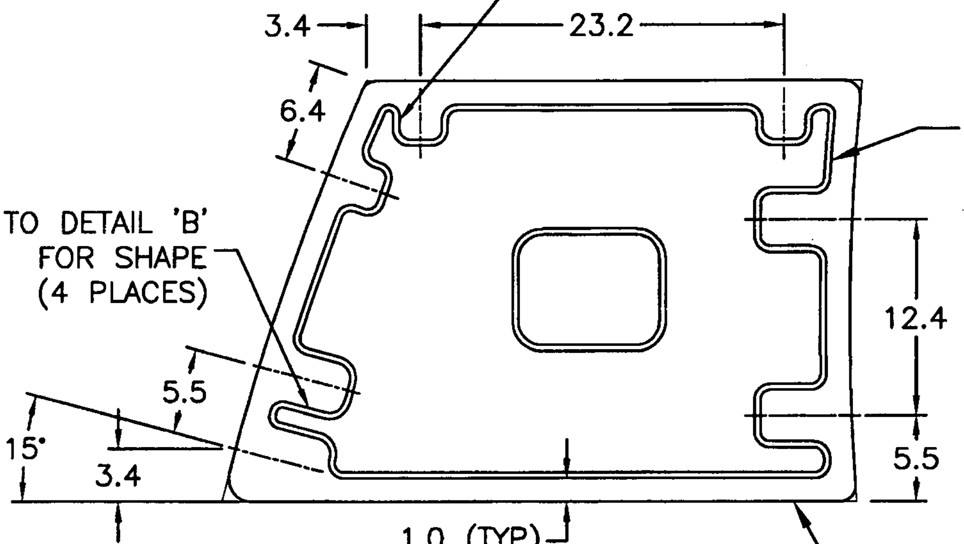
NOTES:
1) USE MOLD DT8005 FOR DOOR LAYUP
2) RESIN: EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40
3) FOAM: 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECELL
4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
5) LAMINATE PER DART QSI 006 4.0
6) LAMINATION SCHEDULE PER THIS DRAWING
7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
8) ALL DIMENSIONS ARE IN INCHES
9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN DS	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3186	REV. D SHEET 2 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

DART

RELEASED 07.02.27

MAIN LAYUP
9 OZ SATIN (9 SQ FEET)
9 OZ SATIN (9 SQ FEET)
FOAM
9 OZ SATIN (9 SQ FEET)
12 OZ UNIDIRECTIONAL
9 OZ SATIN (9 SQ FEET)
RESIN (35–45% BY WEIGHT)
PEEL PLY

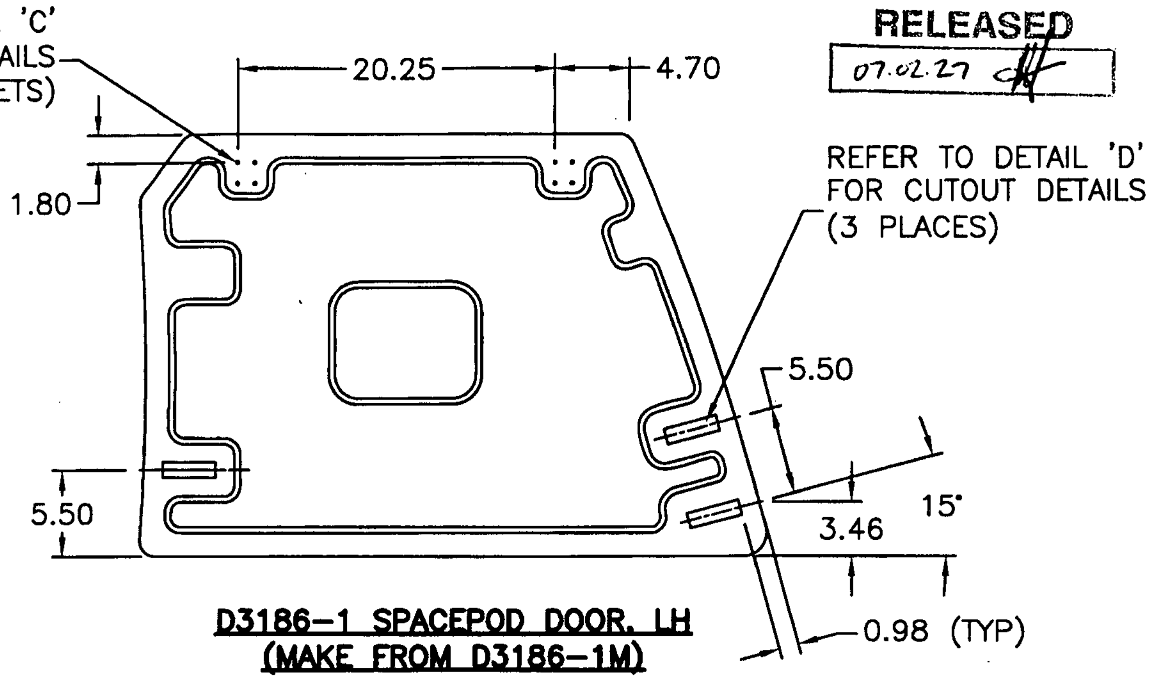


D3186–2M SPACEPOD DOOR AS MOLDED

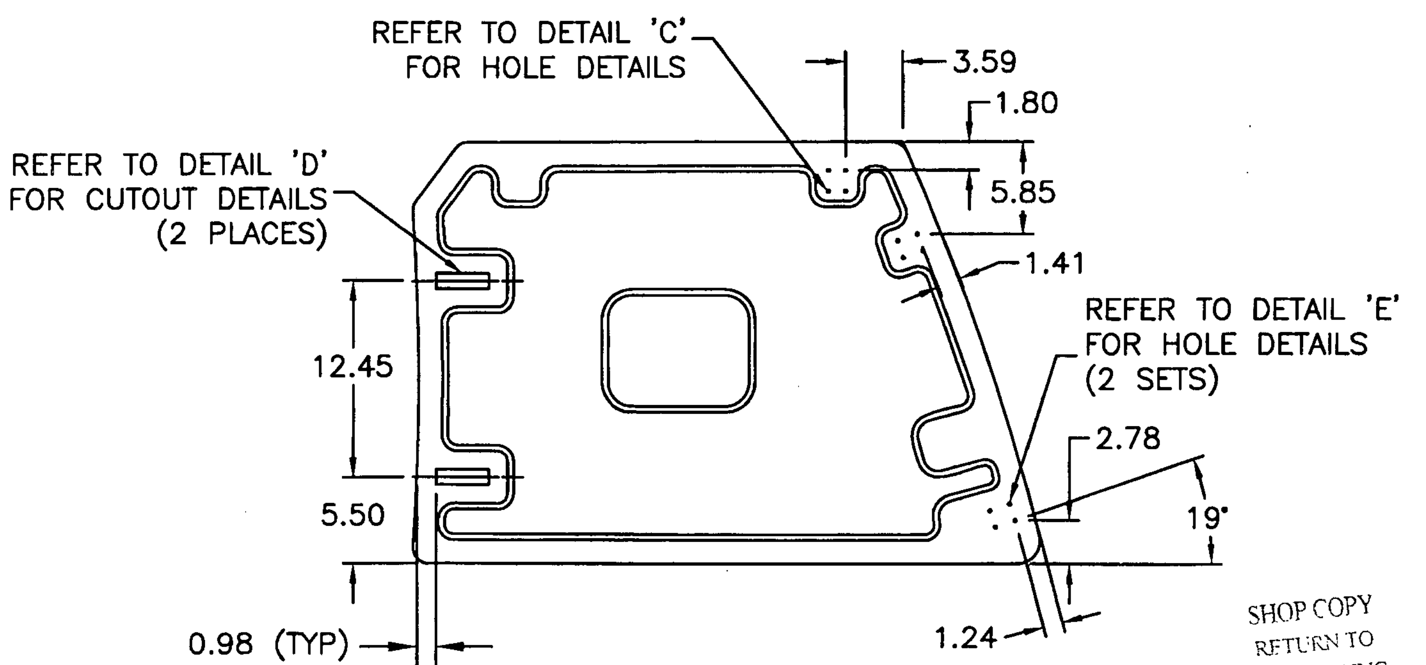
NOTES:
1) USE MOLD DT8006 FOR DOOR LAYUP
2) RESIN: EPOCAST 50–A/9816 OR DERAKANE 470–36/411/510A40
3) FOAM: 3/8", A500 CORE–CELL OR DIVINYCELL OR AIREX OR KLEGECELL
4) FIBRE: 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")
12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")
5) LAMINATE PER DART QSI 006 4.0
6) LAMINATION SCHEDULE PER THIS DRAWING
7) FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144–S
8) ALL DIMENSIONS ARE IN INCHES
9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DS	LE		
CHECKED	APPROVED	DRAWING NO. D3186	REV. D SHEET 3 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS

RELEASED 07.02.27



D3186-1 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

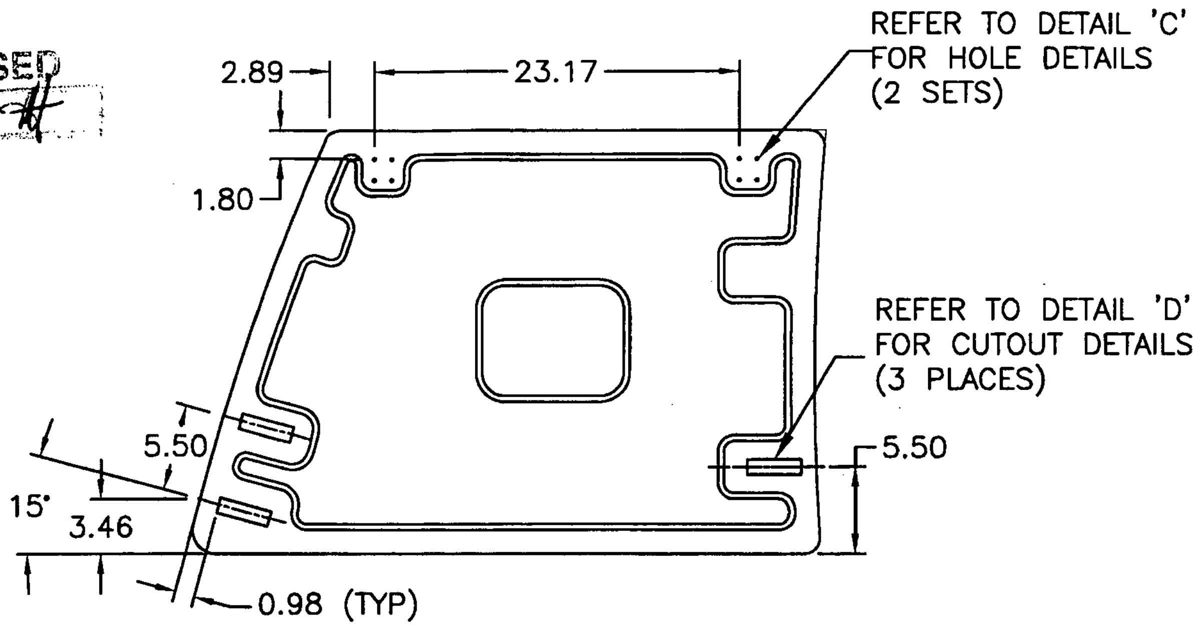


D3186-3 SPACEPOD DOOR, LH
(MAKE FROM D3186-1M)

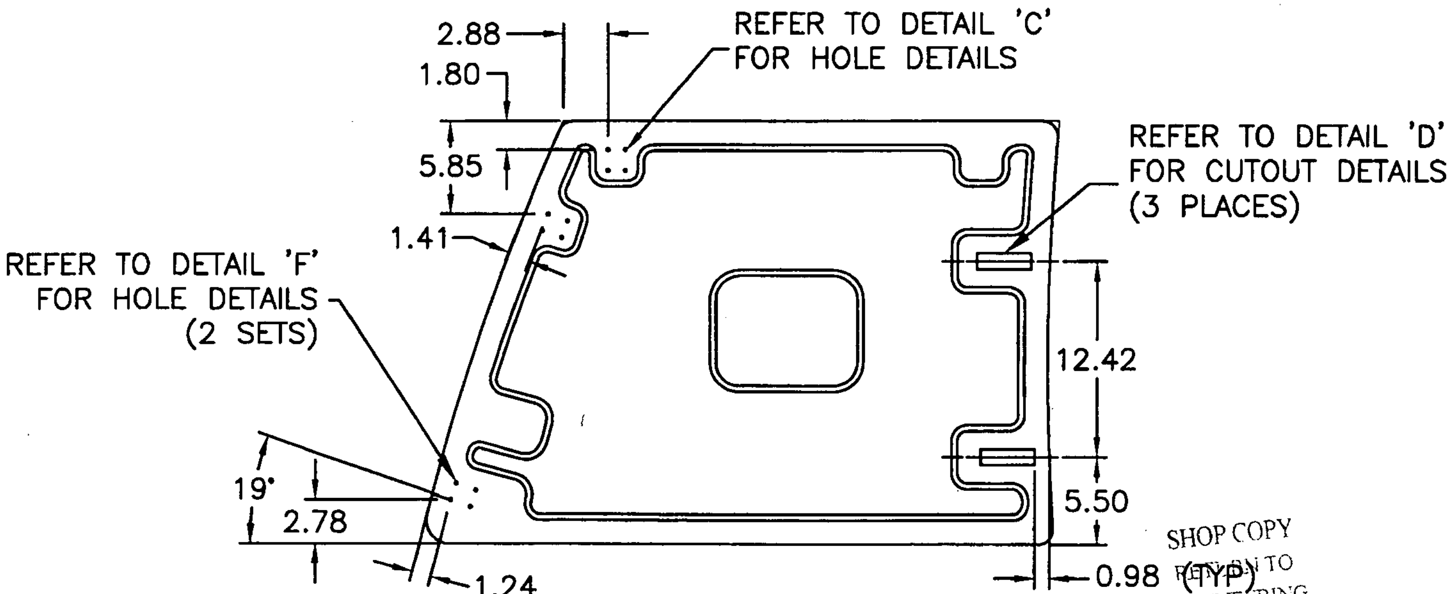
NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DS	LE		
CHECKED	APPROVED	DRAWING NO. D3186	REV. D SHEET 4 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS



D3186-2 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

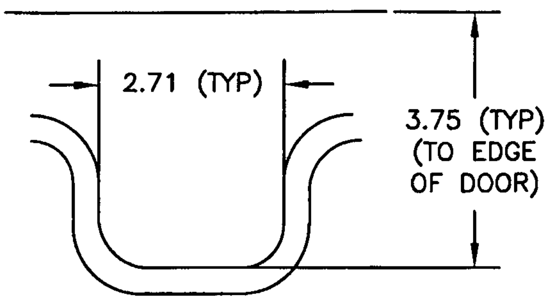


D3186-4 SPACEPOD DOOR, RH
(MAKE FROM D3186-2M)

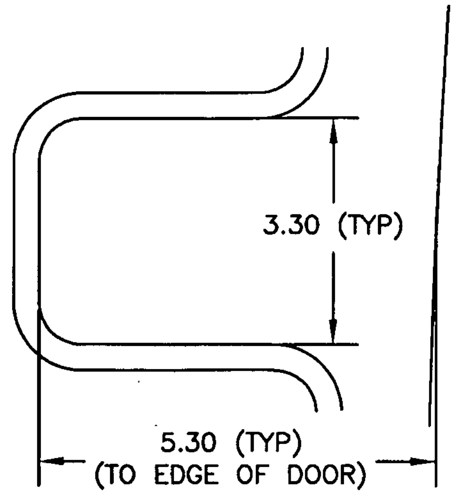
NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

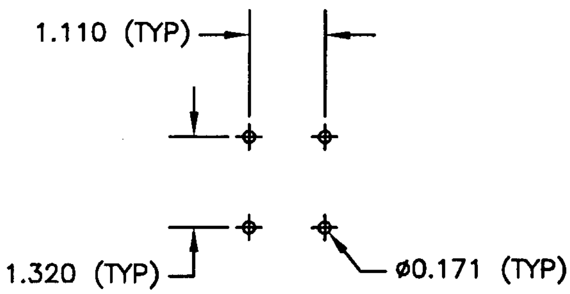
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DS	LE		
CHECKED	APPROVED	DRAWING NO. D3186	REV. D SHEET 5 OF 5
DATE 07.02.22		TITLE SPACEPOD DOOR	SCALE NTS



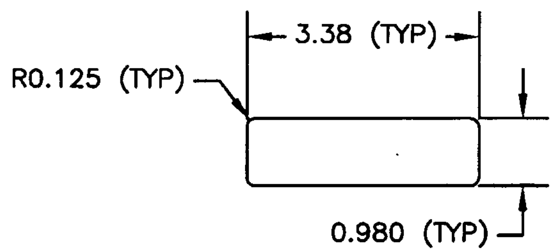
DETAIL A



DETAIL B

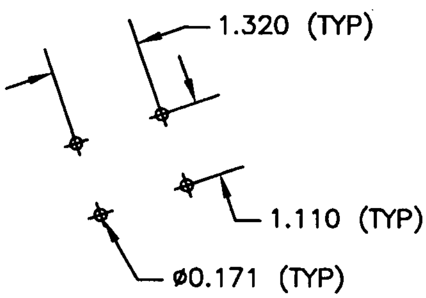


DETAIL C

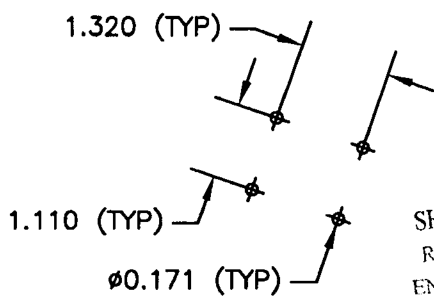


NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

DETAIL D



DETAIL E



DETAIL F

NOTES:
1) ALL DIMENSIONS ARE IN INCHES
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED